

Date: Monday, 7/9/2007 3:45:46 PM  
 User: Kim Johnston

## Process Sheet

32

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SPACEPOD ASSEMBLY RH
Job Number	: 33437		
Estimate Number	: 10799		
P.O. Number	: <i>N/A</i>	Part Number	: D350600142
This Issue	: 7/9/2007	S.O. No.	: <i>N/A</i>
Prsht Rev.	: NC	Drawing Number	: IIN REV.C PG11,18-21
First Issue	: <i>N/A</i>	Project Number	: N/A
Previous Run	: 31122	Drawing Revision	: E, C
		Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 8/5/2007
Checked & Approved By	: <i>[Signature]</i>	Qty:	1 Um: Each
Comment	Est Rev:D 05.04.14 Incorporated procedures from D3187-1/-2 K J/JLM Est Rev:E 06-11-20 As per DS19335 JLM est rev F 07.02.07 iin rev.c ec		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1:0

DC

DOCUMENT CONTROL



KS 07.07.30 ①

Comment: DOCUMENT CONTROL

Photocopy bluefile and type labels as per PPP D350-600-141 CHG003

E 07/10/05

2:0

33437A

SWITCH RELOCATION KIT



D350-600349



Comment: Sub-Component SWITCH RELOCATION KIT

B344/99

W 7/11/05

3:0

33437B

SPACEPOD BODY RH



Comment: Sub-Component SPACEPOD BODY RH

D3188-2M Batch: B 33437B

ml 07/10/18

4:0

33437C

SPACEPOD DOOR RH



Comment: Sub-Component SPACEPOD DOOR LH

D3186-2 B 33437C

ml 07/10/18

5:0

D31872

Spacepod Floor



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3187-2

Floor B 31836 =

1 D3186-2

Door (ref) 33437C

1 D3188-2M

Body(ref) 33437B

GP

GP 07/10/19

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Date: Monday, 7/9/2007 3:45:47 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY RH

Job Number: 33437

Part Number: D350600142

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

ALS41032130

Insert



*gs.*



Comment: Qty.: 28.0000 Each(s)/Unit Total : 28.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

28 ALS4-1032-130 Insert

*M105730*

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Transfer drill (#30) from D3187-2 into D3188-2.

*> Use jig DT 8971*

2-Open holes in D3188-2 body floor to Ø0.297".

3-Install inserts in D3188-2 as per Dwg D3188.

4-Open holes in D3187-2 aluminum floor to 0.250" per dwg D3187

*> already done*

5-Deburr holes in D3187-2

*> already done*

*mlo 7/10/24*

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*5 7/10/24*

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

\*\*\*\*\*D3187-2 floor only\*\*\*\*\*

Chemical Conversion Coat as per QSI 005 4.1

*already done*

*N/A*

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

\*\*\*\*\*D3187-2 floor only\*\*\*\*\*

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

*already done*

*N/A*

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*already done*

*N/A*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/10/24	7	Now using DT8971 (R/H) for holes in floor body. The floor is already done  Permanent change	<del>AD</del> <del>07/11/05</del>	07/11/05		<del>AD</del> <del>07/11/05</del>	G 7/10/24

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
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Drawing Name: SPACEPOD ASSEMBLY RH

Job Number: 33437

Part Number: D350600142

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC5

INSPECT WORK TO CURRENT STEP



N/A

Comment: INSPECT WORK TO CURRENT STEP

13.0

D2986

Black Neoprene foam .125



GP



Comment: Qty.: 5.9010 sf(s)/Unit Total : 5.9010 sf(s)

Pick:

Qty Part Number

Description

Batch

5.62SF D2986

Neoprene Foam

B30632

14.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut D2986 Neoprene Foam per template D2986T2

2-Attach Neoprene Foam using Contact Cement

A/R Contact Cement

Batch: M102565

M107/10/25

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

E-A10/25

16.0

AN3235020935

WASHER



GP



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

WASHER

batch:

M104760

17.0

D35672

DECAL



GP



Comment: Qty.: 2.0000 Each(s)/Unit Total : 1.0000 Each(s)

DECAL

batch:

B31128

PTO

18.0

MS20426AD45

Rivet



GP





Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Batch:

M3459

GP 07/10/190

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/10/18	17	one label missing. Need <u>Two</u> for making the Assy. Permanent Change			07/10/05			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
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			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

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Job Number: 33437

Part Number: D350600142

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

D35491

BRACKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
BRACKET  
batch: B31125-

*CP*

20.0

D2237

Striker Plate



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)  
Pick:  
Batch: B33486-

*CP*

21.0

D35547

BALL STUD



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
BALL STUD  
batch: B30210-

*CP*

22.0

AN960JD516

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Pick:  
Batch: M104156-

*CP*

23.0

D30153

Lock Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Pick:  
Batch: B34197-

*CP*

24.0

MS20426AD46

Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
Rivet  
Batch: M103395-

*CP*

25.0

D35381

HINGE BRACKET



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
HINGE BRACKET  
batch: B33968-


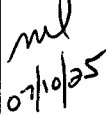



*CP*

*CP 07/10/190*

*PTO*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: D Date: 07/11/06  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/10/05	24	Had to take out one rivet. Because the thickness at this place was <del>too</del> too much. Made Hole bigger		took out one rivet MS 20426 AD 4-6 Scrap it. make hole .156 instead of .128 use one MS 20426 AD 5-7 M7681	 07/10/05	 07/11/05		 07/11/05

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Drawing Name: SPACEPOD ASSEMBLY RH

Job Number: 33437

Part Number: D350600142

Job Number:



Seq. #:

Machine Or Operation:

Description :

26.0

D2179

Doubler



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Batch: B30630 -

*CP*

27.0

AN526C832R14

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Screw

batch: M9216 -

*CP*

28.0

AN960JD8

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

batch: M105516 -

*CP*

29.0

MS21042L08

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

batch: M104812 -

*CP*

30.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble D3187-2 floor with D3188-2 body as per Dwg ICA-D350-600

\*\*\*Hardware on previous steps is for body & floor\*\*\*\*

N/A *mul*

31.0

D35529

CARBON STEEL GAS SPRING



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

CARBON STEEL GAS SPRING

batch: B30673 -

*CP*

32.0

MS270390811

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

batch: M104427 -

*CP*

*CP 7/10/170*

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

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Drawing Name: SPACEPOD ASSEMBLY RH

Job Number: 33437

Part Number: D350600142

Job Number:



Seq. #:

Machine Or Operation:

Description :

33.0

AN960JD8

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

batch: M105516-

*CP*



34.0

NAS1515H3

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

batch: M105164-

*CP*



35.0

MS21042L08

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

batch: M104812-

*CP*



36.0

D2464

3/4 Seal



Comment: Qty.: 11.3400 f(s)/Unit Total : 11.3400 f(s)

3/4 Seal

Cut 127.00" long batch: B30681-

*CP*



37.0

D2586

Door Latch



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Door Latch

batch: B32504-

*CP*



38.0

D2585

Latch Clamp



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Latch Clamp

batch: B33487-

*CP*



39.0

D2621

Latch Plate



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Latch Plate

batch: B28916-

*CP*



*CP 507/10/198*

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

**NOTE:** Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY RH

Job Number: 33437

Part Number: D350600142

Job Number:



Seq. #:

Machine Or Operation:

Description :

40.0

MS27039115

Screw



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)  
Screw  
batch: M105108-

*CP*



41.0

AN960JD10

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)  
Washer  
batch: M100151-

*CP*



42.0

MS21042L3

Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)  
Nut  
batch: M104625-

*CP*



43.0

D28571

Hinge Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Hinge Bracket  
batch: B31832-

*CP*



44.0

D2228

Backing Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Backing Plate  
batch: B30679-

*CP*



45.0

AN526C832R10

Screw



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)  
Screw  
batch: M104603-

*CP*



46.0

AN960JD8

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)  
Washer  
batch: M105516-

*CP*



*CP 7/10/00*

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 7/9/2007 3:45:47 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY RH

Job Number: 33437

Part Number: D350600142

Job Number:



Seq. #:

Machine Or Operation:

Description :

47.0

MS21042L08

Nut



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Nut

batch: M104812

*CP*



48.0

D28572

Hinge Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Hinge Bracket

batch: B33453

*CP*



49.0

D35481

BRACKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BRACKET

batch: B30245

*CP*



50.0

D35547

BALL STUD



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BALL STUD

batch: B30210

*CP*



51.0

AN960JD516

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Washer

batch: M104156

*CP*



52.0

D30153

Lock Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Lock Nut

batch: B34197

*CP*



(Ptc)

53.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble D3186-2 door with D3188-2 body as per Dwg ICA-D350-600

\*\*\*Hardware on previous steps is for door ass'y\*\*\*\*

*CP*



*ml 07/10/25*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: D Date: 07/11/04  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/10/09	53	QC ask to change 2 rivets MS 20426 AD4-P	<i>[Signature]</i>	Take out 2 rivets, scrap them. Mist one, I have to take out 10 rivets and scrap one D3549-1 Bracket Scrap on D2237 striker plate the Edge of the door was to smooth.	<i>[Signature]</i> 07/10/29	<i>[Signature]</i> 07/11/01	<i>[Signature]</i> 07/11/01	<i>[Signature]</i> 07-10-29
↓	↓	↓	<i>[Signature]</i>	Install New one D3549-1 Bracket D2237 Striker plate <del>1 rivet MS 20426 AD4-P</del> 1 rivet MS 20426 AD5-7M 7681	<i>[Signature]</i> 07/11/01	<i>[Signature]</i> 07/11/01	<i>[Signature]</i> 07/11/01	<i>[Signature]</i> 07-10-29
				ALCO + 100 R ASSY This time only				

NOTE: Date & initial all entries



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Part Number: D350600142

Job Number:



Seq. #:

Machine Or Operation:

Description :

54.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*E 7/11/01*

55.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk Spacepod top surface of Pod as per Dwg D3188 & QSI 005 4.4

Batch:

*M106030*

*M-L*

*07/11/02*

*(IX)*

56.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Wing Walk

*E 7/11/05*

57.0

K10018

Spacepod Hardware Kit



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 K10018

Spacepod Hardware Kit

*B30869*

1 D3187-1(Ref)

Spacepod Floor

*37836*

*E 7/11/05*

58.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

*E 7/11/05*

59.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-600-142

Location:

PPP Rev:

*D*

*1/11/05*

*1/11/05*

*1/11/05*

60.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*D 07/11/06*

Job Completion



*1/11/06*

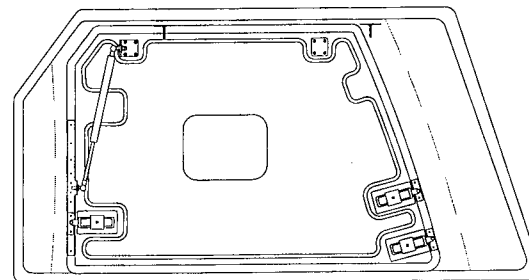
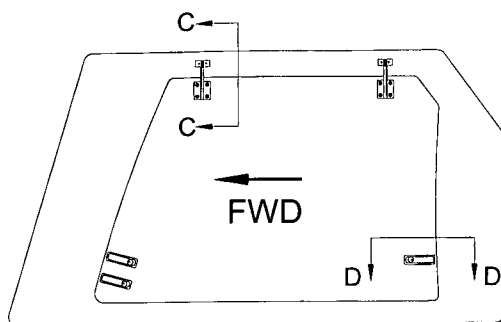
W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

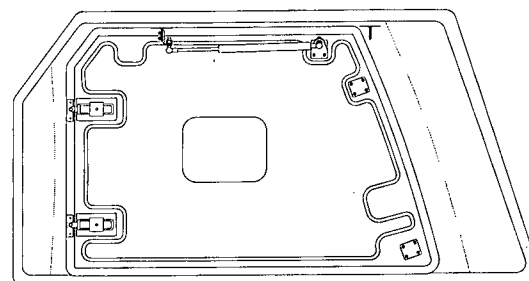
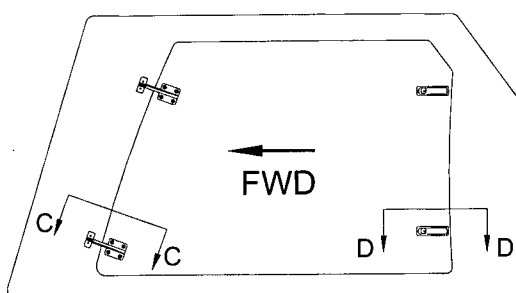
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

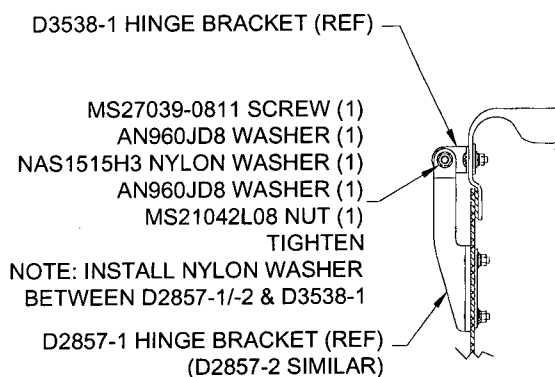
NOTE: Date & initial all entries



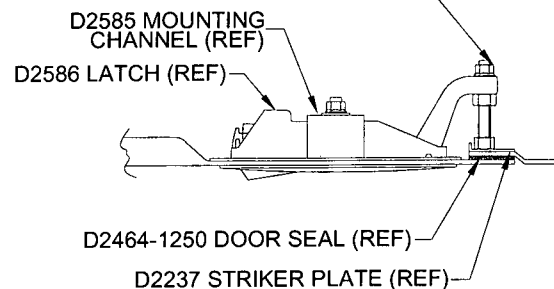
**FIGURE 6(a). -141 SPACEPOD KIT (-142 OPPOSITE, -143 SIMILAR)**  
(OUTSIDE VIEW SHOWN ON LEFT; INSIDE VIEW SHOWN ON RIGHT)



**FIGURE 6(b). -241 SPACEPOD KITS (-242 OPPOSITE, -243 SIMILAR)**  
(OUTSIDE VIEW SHOWN ON LEFT; INSIDE VIEW SHOWN ON RIGHT)



ADJUST SCREW TO ENSURE  
COMPRESSION OF DOOR SEAL  
AND LOCK IN POSITION WITH NUT



#### SECTION 'C-C' HINGE

(-141 SHOWN; -142/-143/-241/-242/-243 SIMILAR)

#### SECTION 'D-D' LATCH

3.2.12 Re-install the following components that were removed from the aircraft in earlier steps:

- Re-install the battery shelf cover or wiring cover per the Aircraft Maintenance Manual. If it is necessary to trim the lower edge to clear the pod floor, touch up the paint using MIL-C-85285 polyurethane paint.
- If applicable, re-install the pop-out float cylinders per the Aircraft Maintenance Manual.
- Re-install the belly panel per the Aircraft Maintenance Manual.

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WORK ORDER

NO. 33437

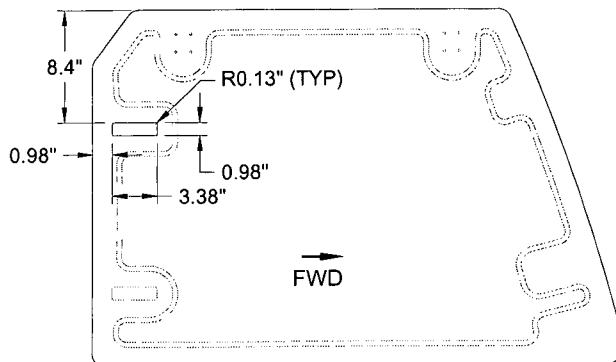
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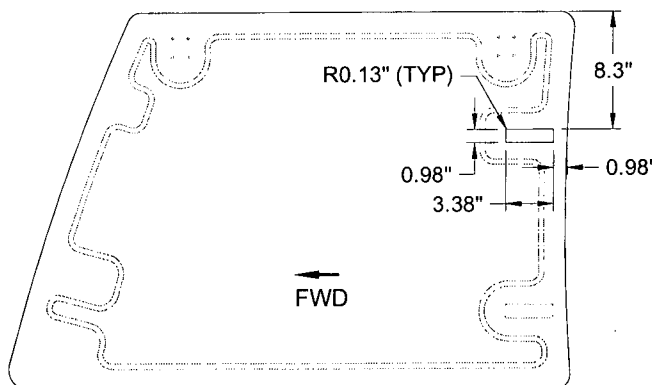
Revision: C

Date: 07.02.20

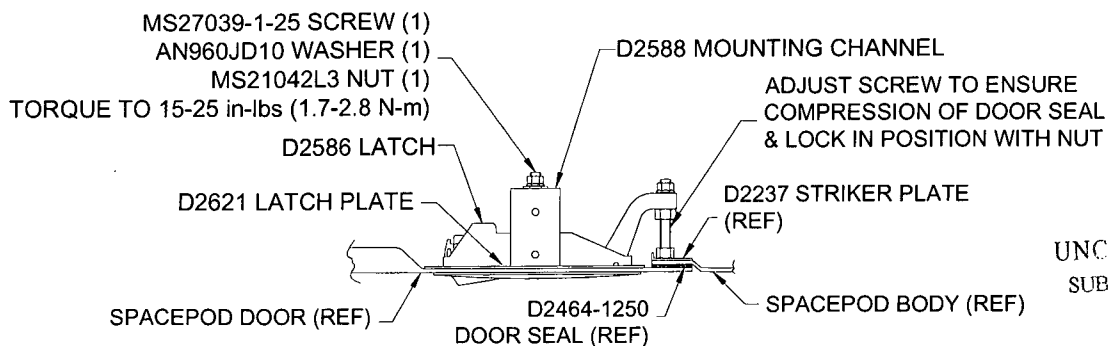
- 3.4.5 After the paint has dried, apply the D2464-1250 neoprene seal where removed in earlier steps.
- 3.4.6 Cut out the rectangular section shown in Figures 14(a) and 14(b). Install the D2586 latch, D2588 mounting channel and D2621 latch plate that were removed earlier from the door using new hardware as shown in Figure 14(c).



**FIGURE 14(a). D3186-1 SPACEPOD DOOR LATCH CUTOUT**  
(APPLICABLE FOR -041I-043I-141I-143 KITS)



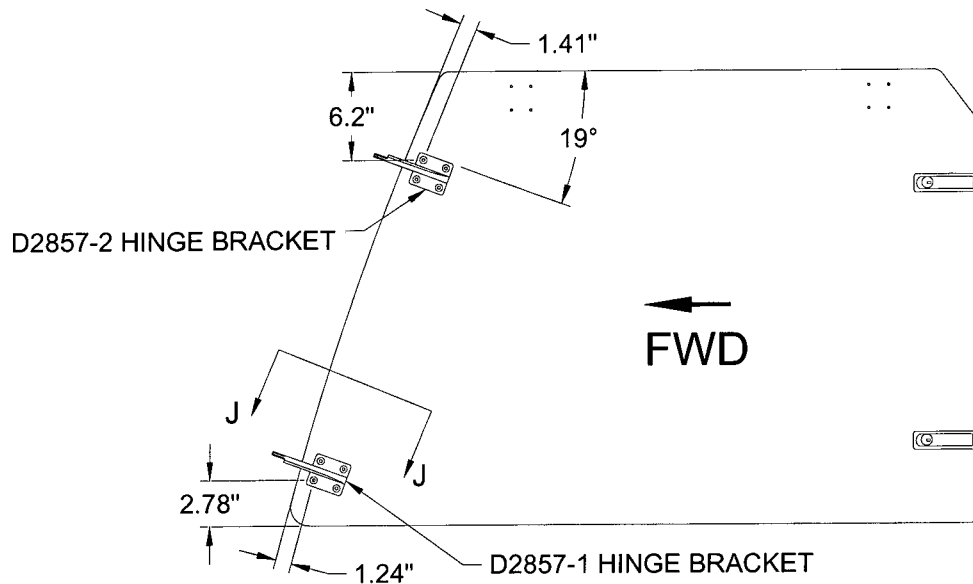
**FIGURE 14(b). D3186-2 SPACEPOD DOOR LATCH CUTOUT**  
(APPLICABLE FOR -042I-142 KITS)



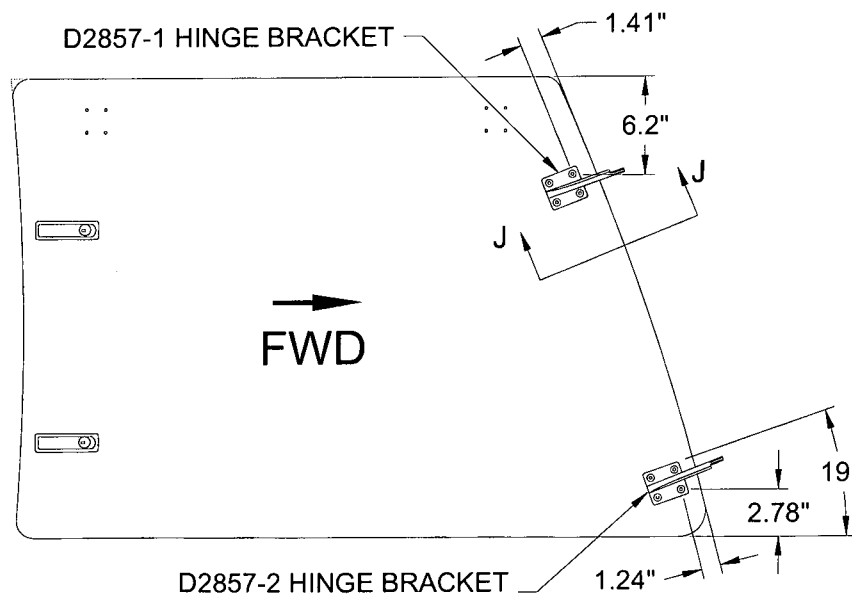
**FIGURE 14(c). LATCH INSTALLATION**  
(SHOWN WITH DOOR INSTALLED ON POD)

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- 3.4.7 Position the D2857-1/-2 hinge brackets as shown in Figure 15(a) for the LH side and Figure 15(b) for the RH side. Transfer drill the  $\varnothing 0.172$ " mounting holes on each bracket to the **Spacepod™** door. Install the hinge brackets as shown in Section J-J.



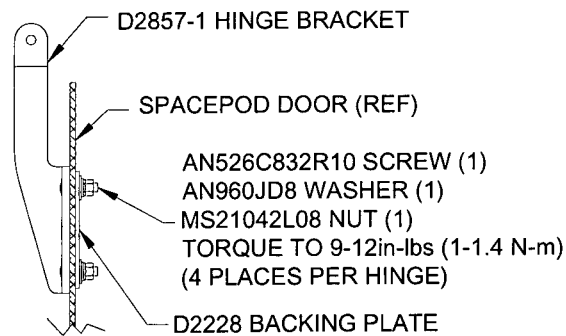
**FIGURE 15(a). HINGE BRACKET POSITION ON LH D3186-1 SPACEPOD DOOR**



**FIGURE 15(b). HINGE BRACKET POSITION ON RH D3186-2 SPACEPOD DOOR**

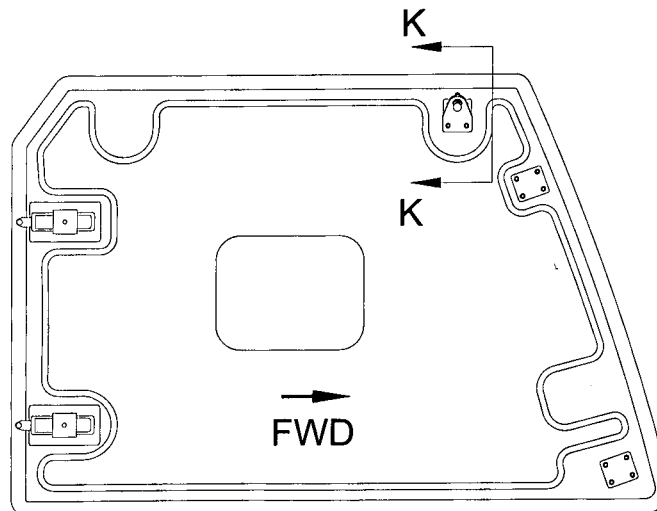
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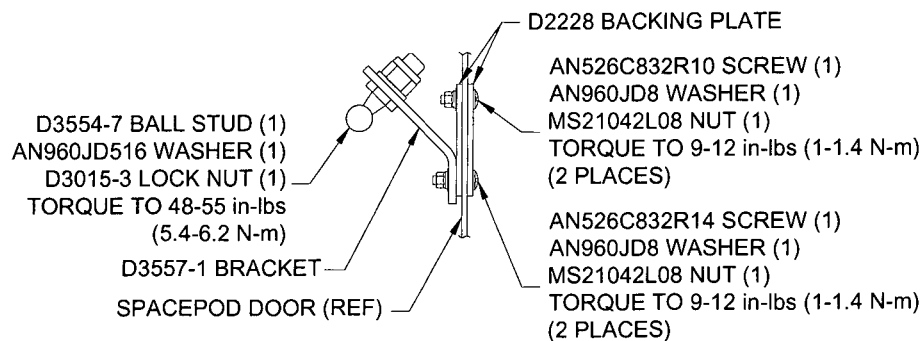


**SECTION 'J-J' HINGE BRACKET INSTALLATION**  
(D2857-1 SHOWN; D2857-2 SIMILAR)

- 3.4.8 Install the D3557-1 bracket in the existing forward hinge mounting holes with the D2228 backing plates and the D3554-7 ball stud as shown in Figure 16.



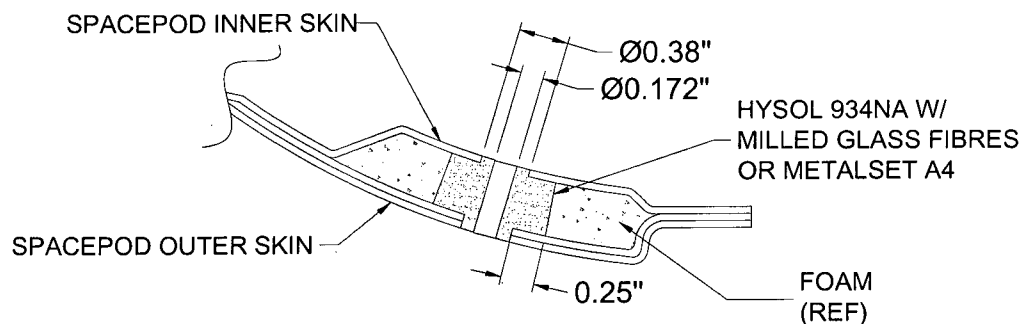
**FIGURE 16. BRACKET AND BALL STUD INSTALLATION ON SPACEPOD DOOR**  
(INSIDE OF D3186-1 SHOWN; D3186-2 OPPOSITE)



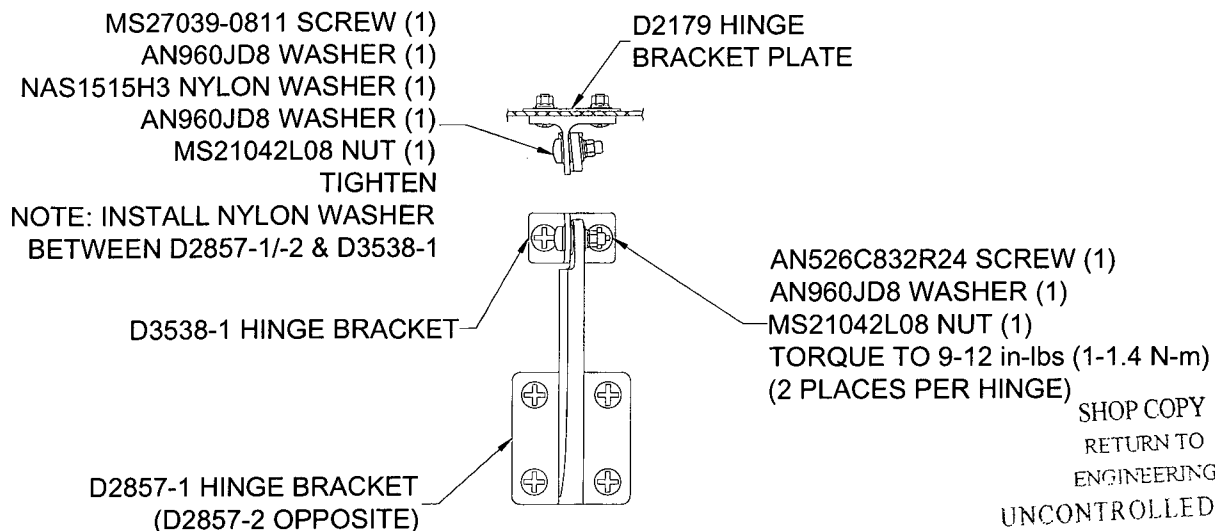
**SECTION 'K-K'**

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- 3.4.9 Install the hinge brackets on the pod as shown in Figures 17(a) and 17(b):
- Assemble the D3538-1 hinge brackets with the D2857-1/-2 hinge brackets as shown in Figure 17(b). Position the door on the pod and transfer mark the mounting holes from the D3538-1 hinge brackets to the **Spacepod™** body.
  - Remove the door and drill Ø0.375" holes where marked. Remove the foam inner layer 0.250" around the hole between the inner and outer skins as shown in Figure 17(a).
  - Apply tape or an equivalent backer to the inner side of the holes to prevent epoxy filler from going through. Fill the cavity between the skins completely with Hysol 934NA mixed with milled glass fibers to in a ratio of 10:1 or Metalset A4. Allow the material to cure.
  - Reposition the **Spacepod™** door and hinges and transfer drill the Ø0.172" D3538-1 hinge bracket mounting holes to the pod.
  - Install the hinge brackets and **Spacepod™** door as shown in Figure 17(b).



**FIGURE 17(a). COMPOSITE MODIFICATION**



**FIGURE 17(b). HINGE BRACKET INSTALLATION**  
(D2857-1 SHOWN; D2857-2 OPPOSITE)

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NO. 33437

Date: Monday, 7/9/2007 3:45:57 PM  
 User: Kim Johnston

## Process Sheet

32

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SPACEPOD DOOR RH  
 Job Number : 33437C  
 Estimate Number : 11099  
 P.O. Number : N/A Part Number : D31862  
 This Issue : 7/9/2007 S.O. No. : N/A Drawing Number : D3186 REV.D  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : SMALL / MED FAB Drawing Revision : D  
 Previous Run : 31122C Material : N/A  
 Due Date : 8/5/2007 Qty: 1 Um: Each  
 Written By : [Signature]  
 Checked & Approved By : [Signature]  
 Comment : Est Rev: A New Issue 05-11-29 JLM  
 est rev B rev D dwg EC 07.03.07

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 33437C01 SPACEPOD DOOR RH



ml 07/10/18

Comment: Sub-Component SPACEPOD DOOR RH

2.0 SMALL FAB 1 SMALL &amp; MEDIUM FAB RESOURCE 1



Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

1-Drill holes and cut out slots for latch as per dwg D3186 (D3186-2 detail)

ml 07/10/24 x1

3.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8B 27/10/24

4.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

ml 07/10/24 (x1)

5.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

D 07/11/06

Job Completion



u 07/11/06



W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA:   *AD*   Date:   *07/11/06*  

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

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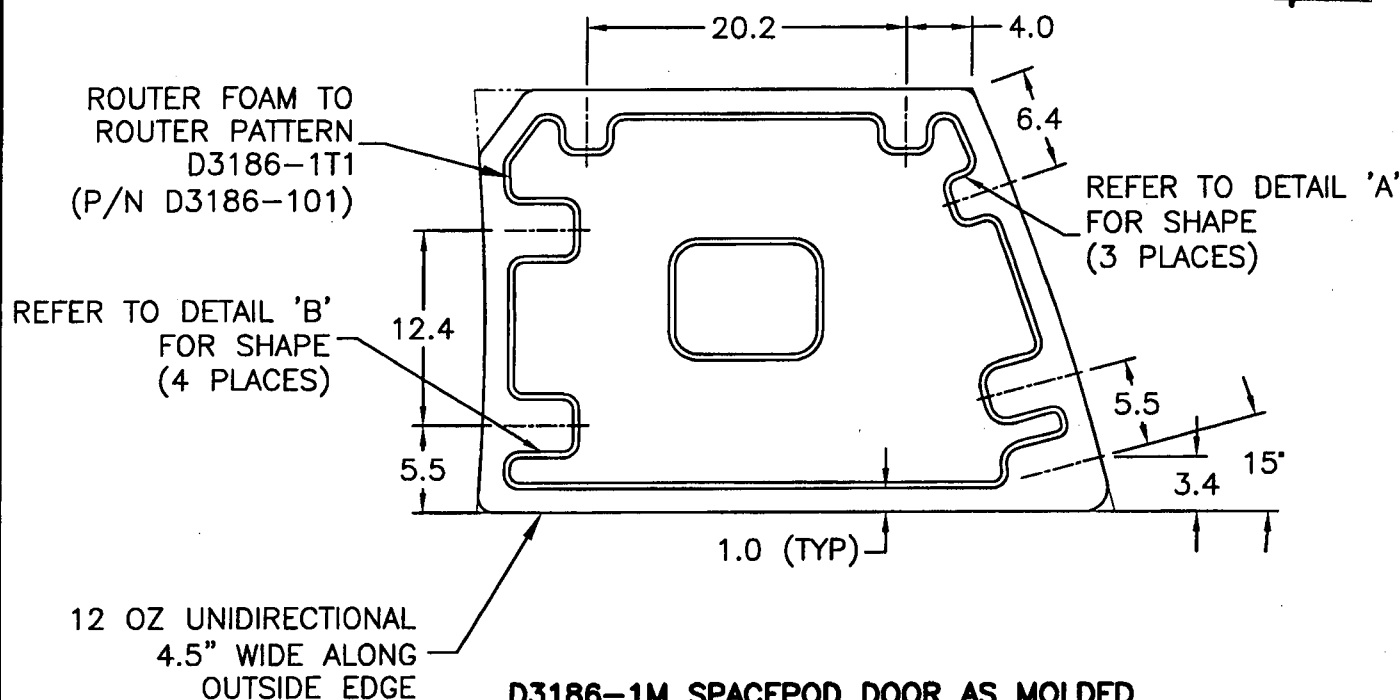
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CHECKED B	APPROVED H	DRAWING NO. D3186	REV. D SHEET 1 OF 5
DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS
A	03.03.27	NEW ISSUE	
B	06.09.25	DIMS UPDATED TO MATCH PRODUCT FOAM PATTERN UPDATED D3186-1M/-2M/-3/-4 ADDED	
C	06.12.13	REMOVED D0600-XXX LABELS	
D	07.02.22	UPDATE DIMENSIONS	

**MAIN LAYUP**

9 OZ SATIN (9 SQ FEET)  
9 OZ SATIN (9 SQ FEET)  
FOAM  
9 OZ SATIN (9 SQ FEET)  
12 OZ UNIDIRECTIONAL  
9 OZ SATIN (9 SQ FEET)  
RESIN (35-45% BY WEIGHT)  
PEEL PLY

**RELEASED**

07.02.27

**D3186-1M SPACEPOD DOOR AS MOLDED****NOTES:**

- 1) USE MOLD DT8005 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYLCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")  
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 8) ALL DIMENSIONS ARE IN INCHES
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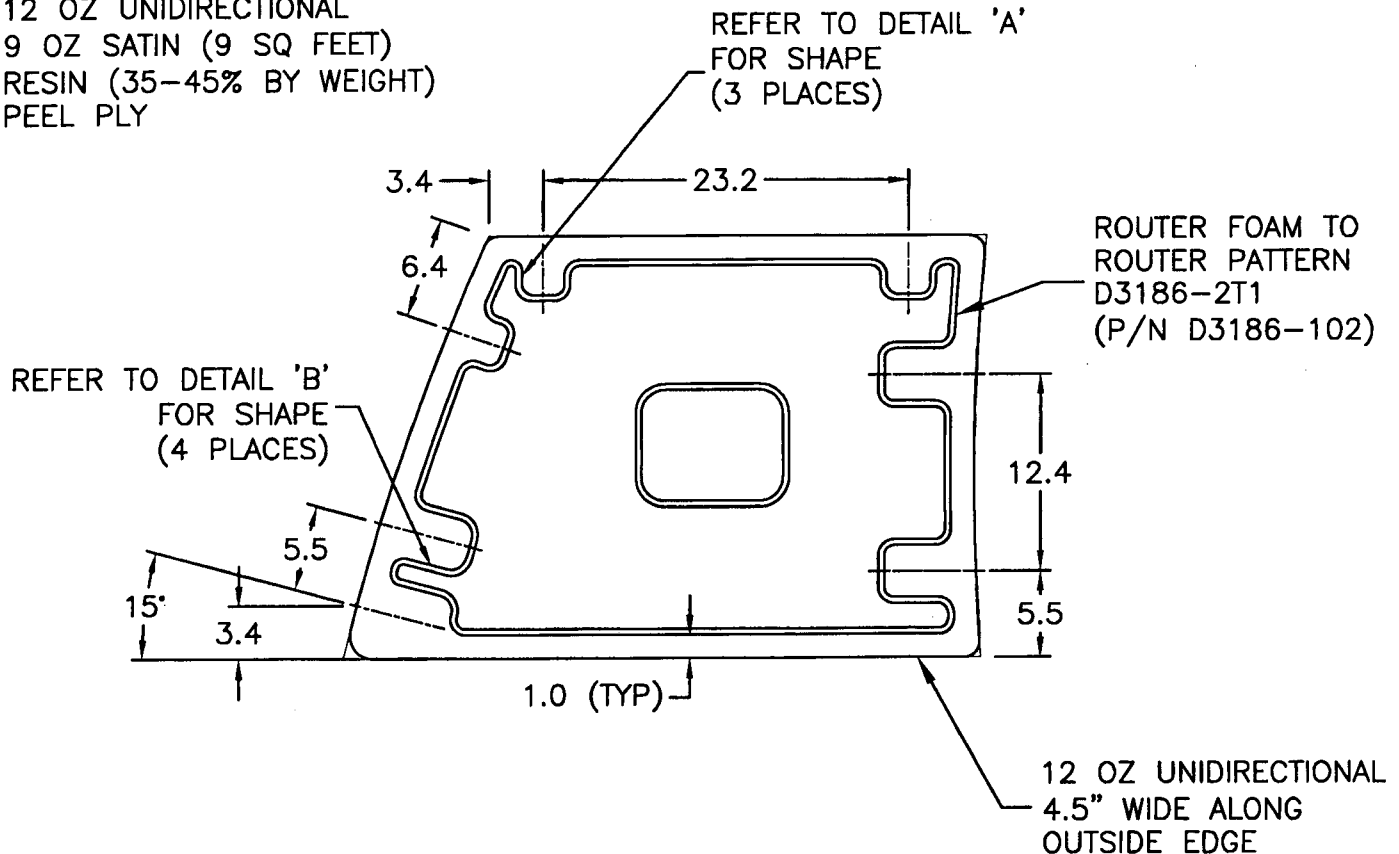
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DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS

**MAIN LAYUP**

9 OZ SATIN (9 SQ FEET)  
9 OZ SATIN (9 SQ FEET)  
FOAM  
9 OZ SATIN (9 SQ FEET)  
12 OZ UNIDIRECTIONAL  
9 OZ SATIN (9 SQ FEET)  
RESIN (35-45% BY WEIGHT)  
PEEL PLY

**RELEASED**

07.02.27 H

**D3186-2M SPACEPOD DOOR AS MOLDED****NOTES:**

- 1) USE MOLD DT8006 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")  
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
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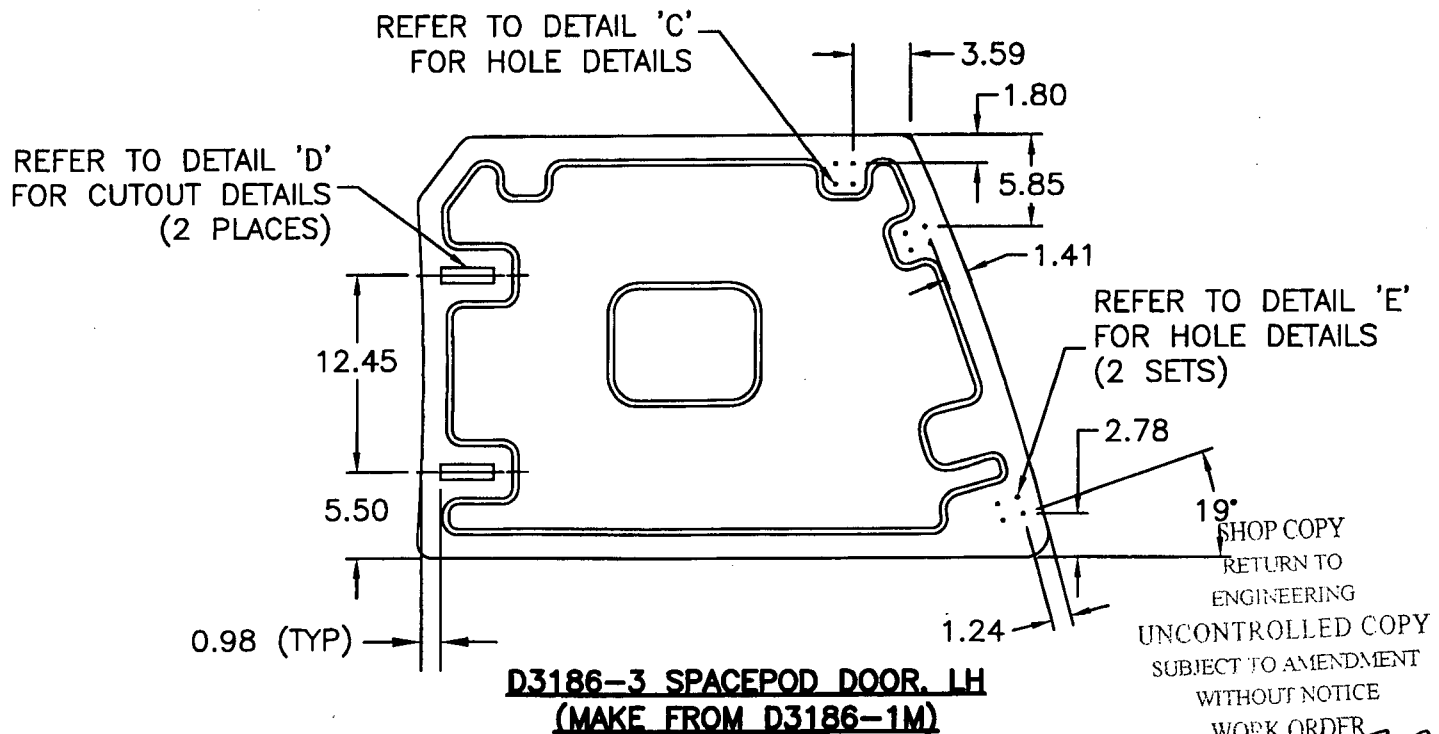
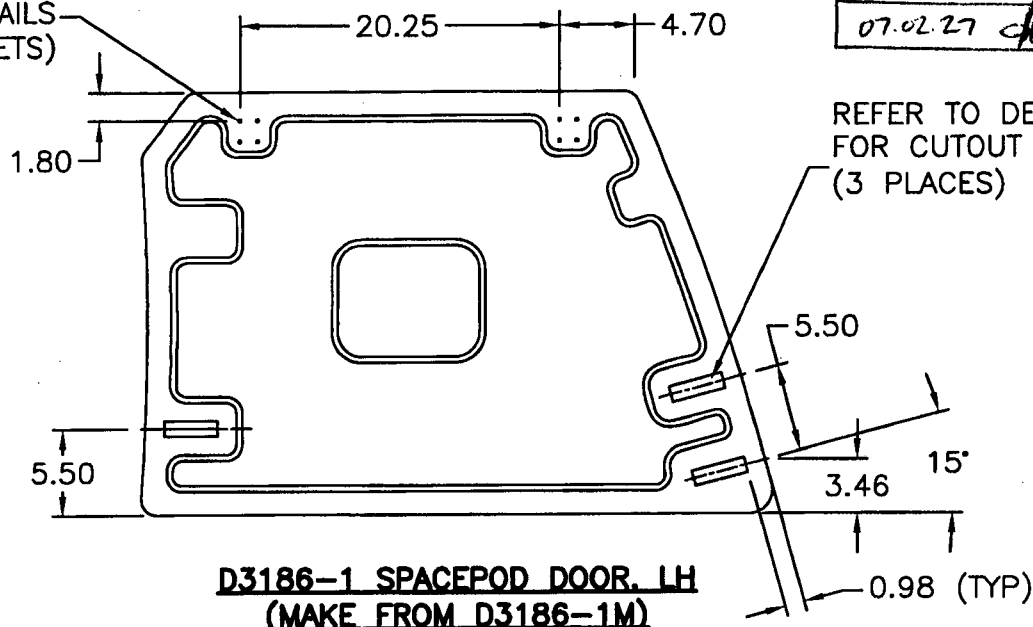
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DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS

REFER TO DETAIL 'C'  
FOR HOLE DETAILS  
(2 SETS)

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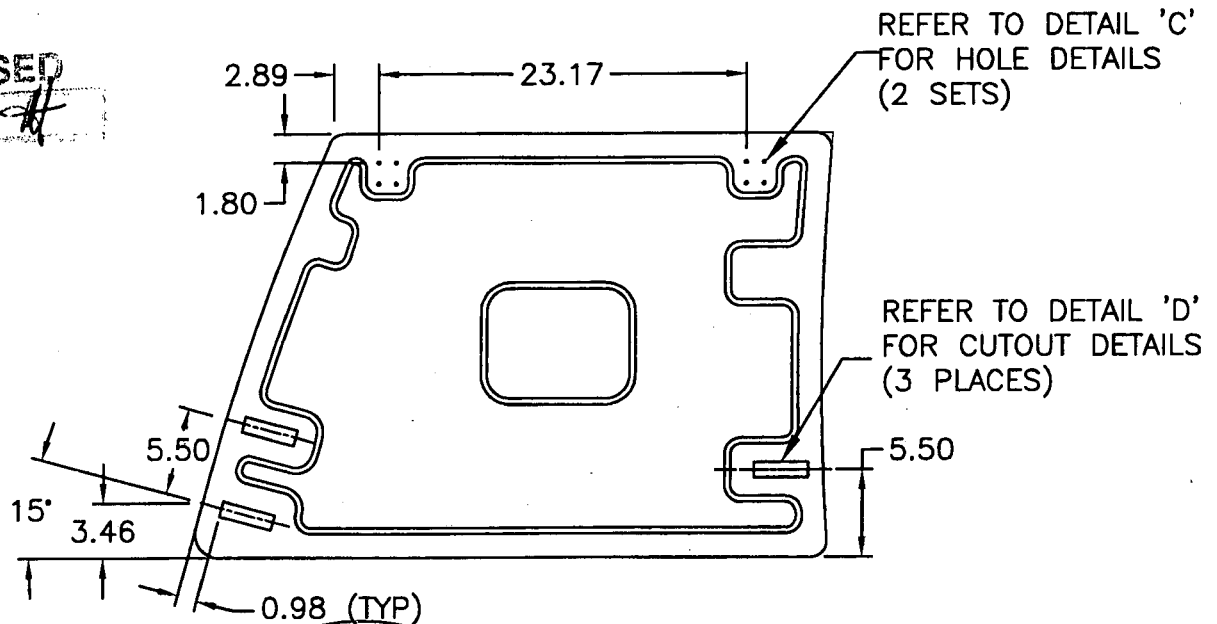
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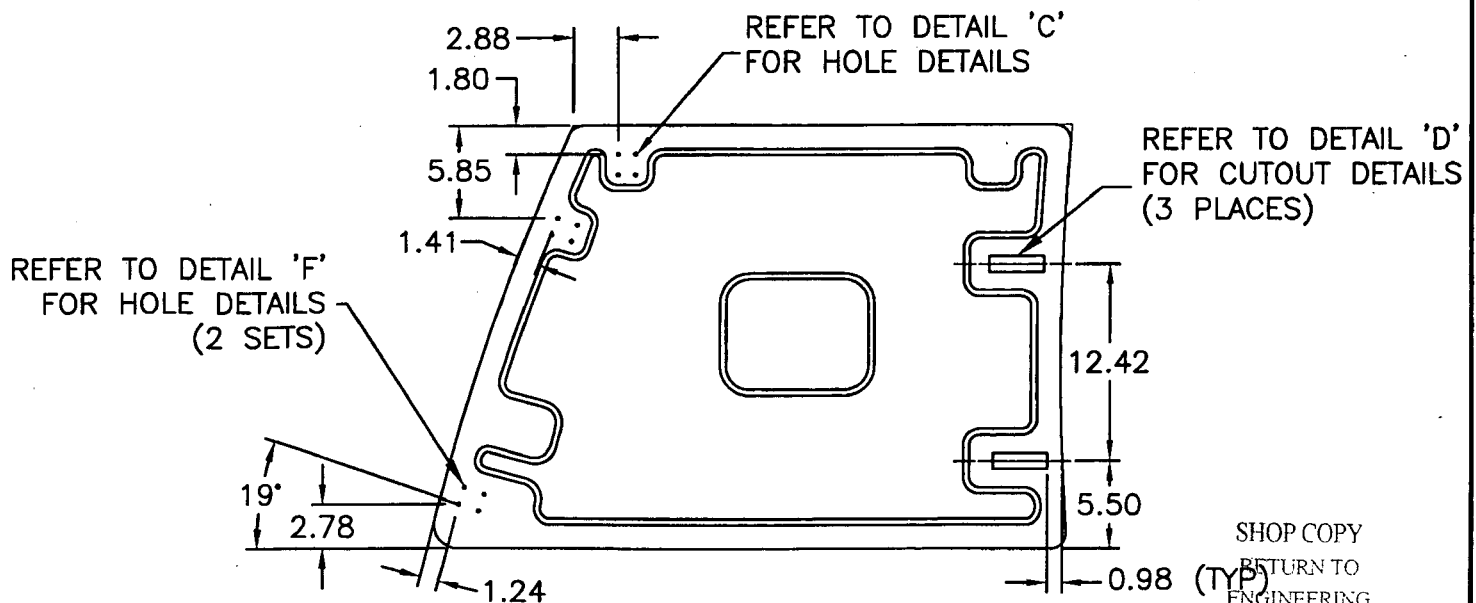
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DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS

**RELEASED**

07-02-27



**D3186-2 SPACEPOD DOOR. RH**  
**(MAKE FROM D3186-2M)**



**D3186-4 SPACEPOD DOOR. RH**  
**(MAKE FROM D3186-2M)**

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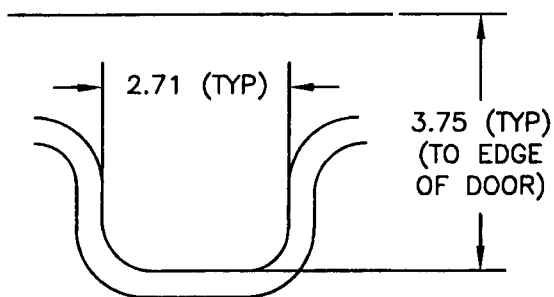
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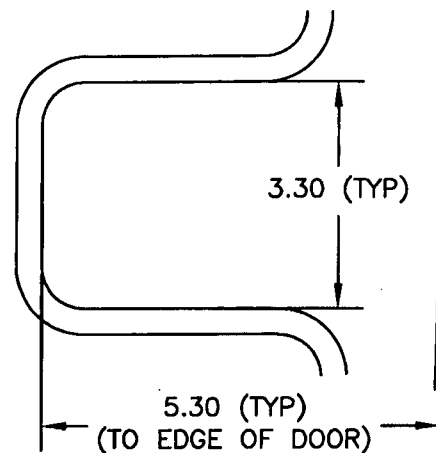
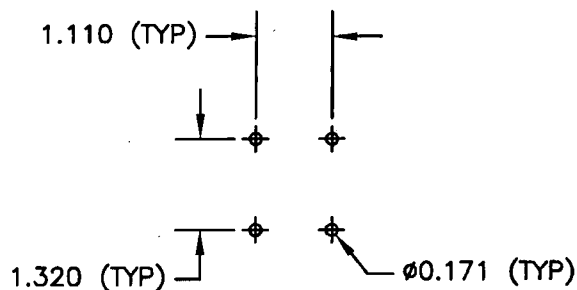
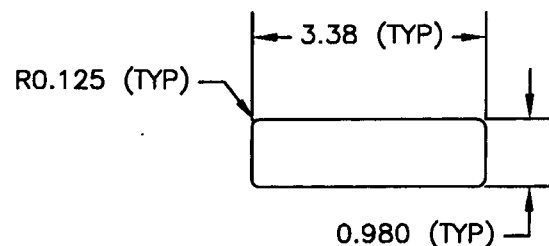
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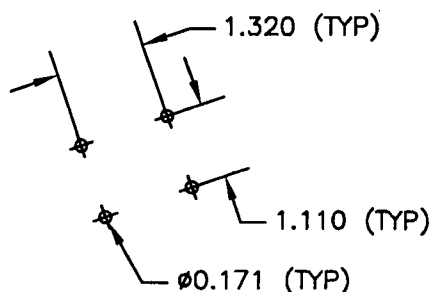
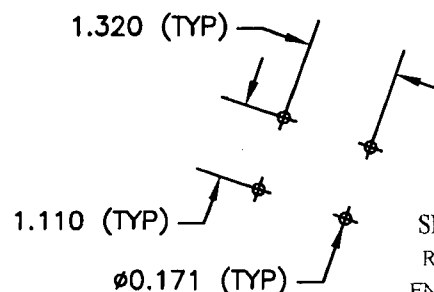
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DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS

**DETAIL A****RELEASED**

07.02.27 [Signature]

**DETAIL B****DETAIL C**

NOTE: ENSURE THAT CUTOUT IS PERPENDICULAR TO EDGE OF DOOR

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Date: Monday, 7/9/2007 3:45:56 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SPACEPOD BODY RH
Job Number	: 33437B		
Estimate Number	: 12596		
P.O. Number	: <i>N/A</i>	Part Number	: D31882M
This Issue	: 7/9/2007	Drawing Number	: D3188 REV.E
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i>	Drawing Revision	: E
Previous Run	: 32298A	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 8/5/2007
Checked & Approved By	: <i>[Signature]</i>	Qty:	1 Um: Each
Comment	Est Rev: A New issue ecn882 06-11-30 EC est rev B rev D dwg 07.03.07 ec est rev C rev E dwg 07.04.16 EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D2213	Aluminum Spacer
-----	-------	-----------------



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)  
 Ship To Delastek

8 D2213 Spacer Batch: *B 30107*

2.0	PG	PURCHASING
-----	----	------------



Comment: PURCHASING  
 Issue P/O: *4132* *C207/07/11* ①  
 Description: D3188-2M BODY  
 SHIP: D2213 Spacers  
 Supplier: Delastek  
 Conformity Certificate and Process sheet required (*42035*)  
 Ship 2 Items from Previous steps

3.0	D31882M	Spacepod Body
-----	---------	---------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
 Spacepod Body

4.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1  
 Receive and inspect for transit damage. Ensure a copy of certification of conformity and process sheet from Delastek is attached.

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: LD Date: 9/16/06  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries



Date: Monday, 7/9/2007 3:45:56 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD BODY RH

Job Number: 33437B

Part Number: D31882M

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Inspect dimensions as per Dwg D3188 .Visual inspection. Check for void spot and pins.

*ml 07/10/18*

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

*ml 07/10/18*

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*ADH. 106*

Job Completion



*4 87.11.06*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

**DART**

DESIGN <b>JB</b>	DRAWN BY <b>CB</b>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <b>LE</b>	APPROVED <b>[Signature]</b>	DRAWING NO. <b>D3188</b>	REV. E SHEET 1 OF 11
DATE <b>07.04.02</b>	TITLE <b>SPACEPOD BODY</b>		SCALE NTS
<b>A</b>	<b>03.04.03</b>	<b>NEW ISSUE</b>	
<b>B</b>	<b>06.10.06</b>	<b>UPDATED DWG TO MATCH PRODUCT ADDED D3188-1M/-2M/-3M/-5/-6/-7</b>	
<b>C</b>	<b>06.12.13</b>	<b>REMOVED D0600-XXX LABELS</b>	
<b>D</b>	<b>07.02.22</b>	<b>UPDATE DIMENSIONS</b>	
<b>E</b>	<b>07.04.02</b>	<b>ADD HYSOL/FIBER OPTION ON SHEET 11</b>	

**RELEASED****07.04.09****GENERAL NOTES:**

- 1) REFERENCE DIMENSIONS MATCH AIRCRAFT CONTOUR AND DOOR OPENING
- 2) LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING

**3) MATERIALS:****RESIN:** EPOCAST 50-A9816 OR DERAKANE 470-36/411/510A40

**FIBER:** 9.7 oz 7781 WEAVE "S" GLASS (9 oz SATIN)  
12 oz UNIDIRECTIONAL FIBERGLASS ("12 oz UNIDIRECTIONAL")  
18 oz ROVING "E" GLASS (18 oz CLOTH)  
OWENS CORNING MILLED FIBERS, "E" GLASS  
3M K20 GLASS BUBBLES

**FOAM:** A500 CORE CELL  
OR DIVINYCELL  
OR AIREX  
OR KLEGECELL  
FILL VOIDS IN FOAM WITH PASTE MADE FROM MILLED FIBERS & RESIN

**4) MOLD SCHEDULE:**

PART	LAYUP	TRIM AND DRILL
D3188-1M/-1/-5	DT8003	DT8501
D3188-2M/-2/-6	DT8004	DT8502
D3188-3M/-3/-7	DT8500	DT8501

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WORK ORDER

NO. **33437B**

5) APPLY ANTI-SKID PAINT TO TOP SURFACE OF PODS PER QSI 005 4.4

6) FINISH: INSIDE/OUTSIDE WITH GREY DUPONT HIGHBUILD PRIMER 1144-S

7) ALL DIMENSIONS ARE IN INCHES

8) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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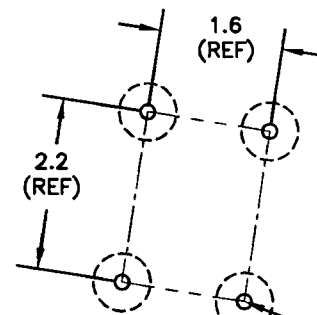
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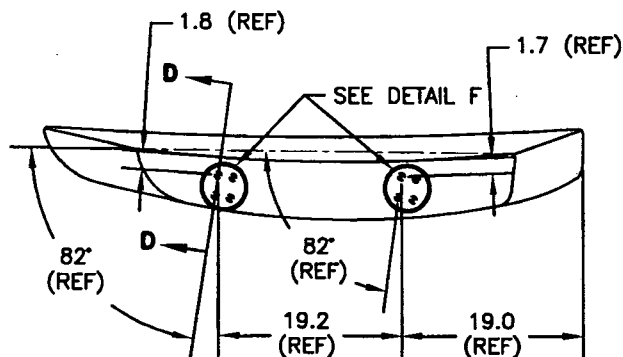
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07.04.02

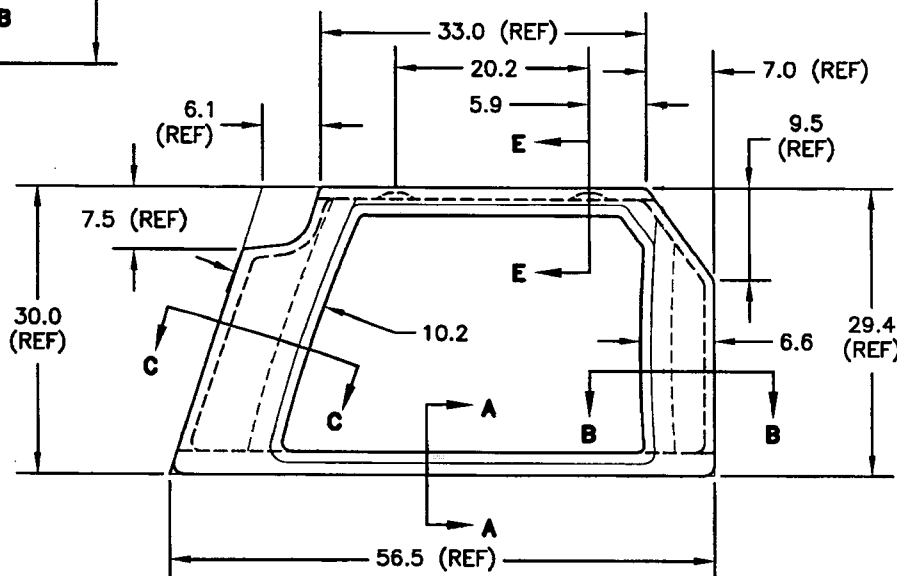
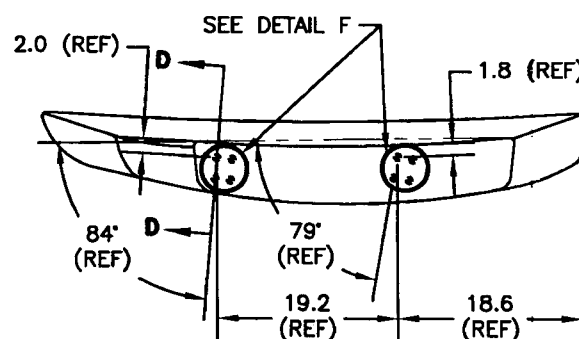
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CHECKED	CE	APPROVED	[Signature]	DRAWING NO.
DATE	07.04.02			D3188
		TITLE		SPACEPOD BODY
				SHEET 2 OF 11
		SCALE		NTS



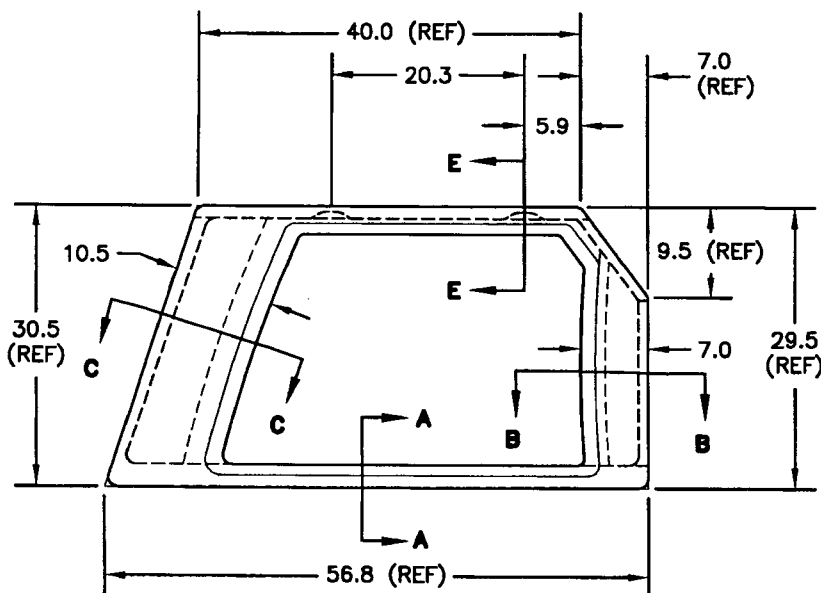
**DETAIL F**



**D3188-1M SPACEPOD BODY**



**D3188-3M SPACEPOD BODY**



**D3188-1M SPACEPOD BODY**

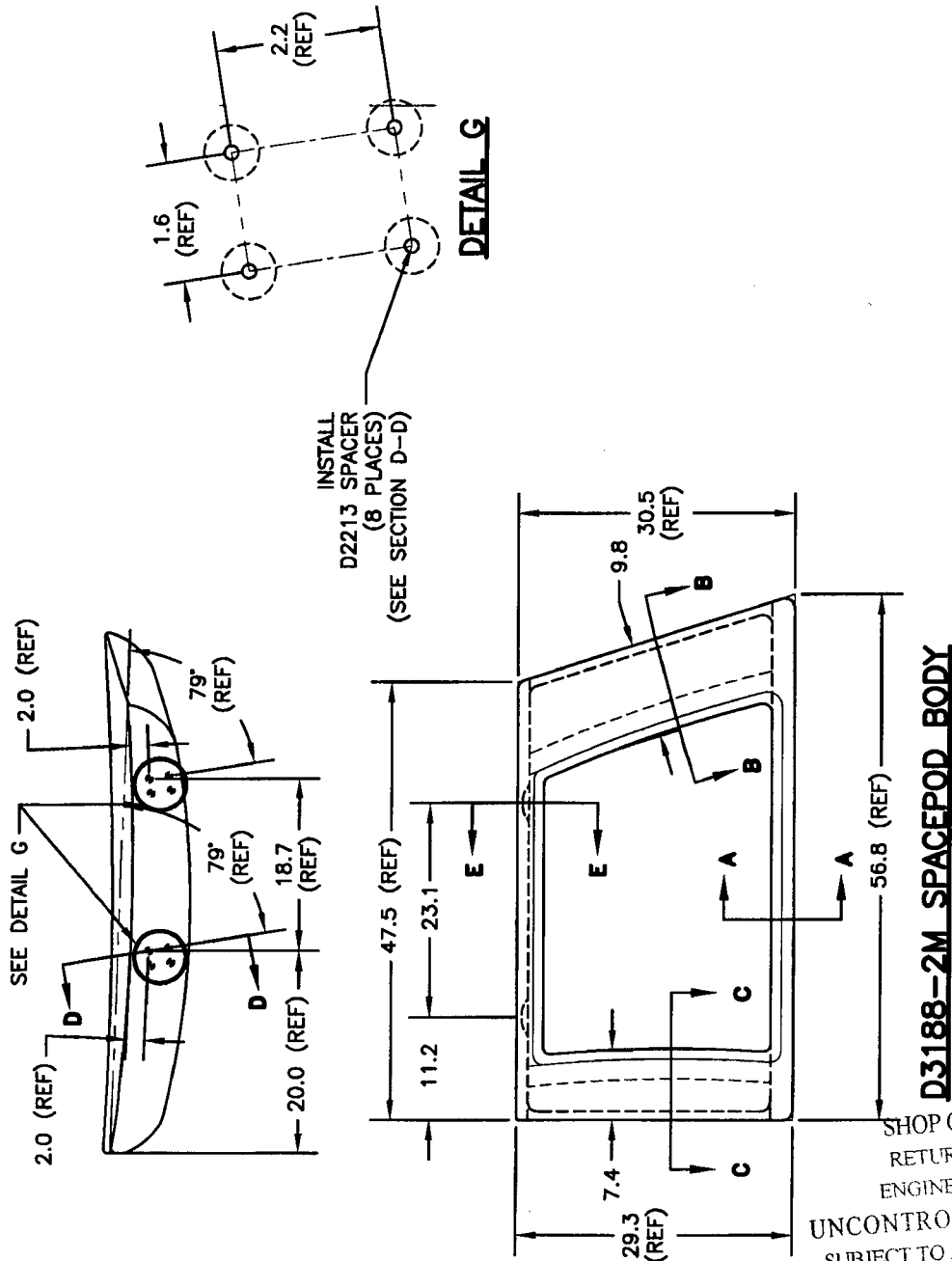
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NO 33457B

**D3186-1M/-3M NOTES:**

- 1) REFERENCE DIMENSIONS ARE FROM DT8003/DT8500 AND DT8501.
- 2) SEE SHEET #4 FOR SECTION VIEWS.

**DART**

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DATE <b>07.04.02</b>	TITLE <b>SPACEPOD BODY</b>		SCALE NTS

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**D3188-2M NOTES:**  
1) REFERENCE DIMENSIONS ARE FROM DT8004 AND DT8502.  
2) SEE SHEET #4 FOR SECTION VIEWS.

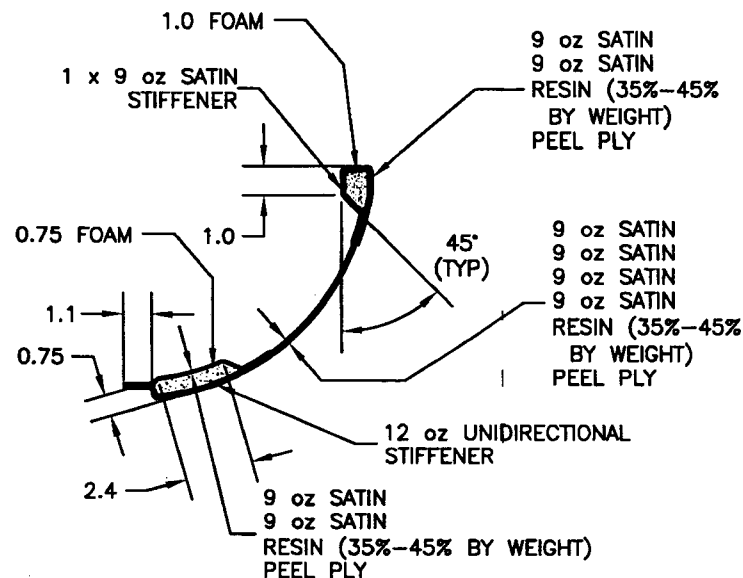
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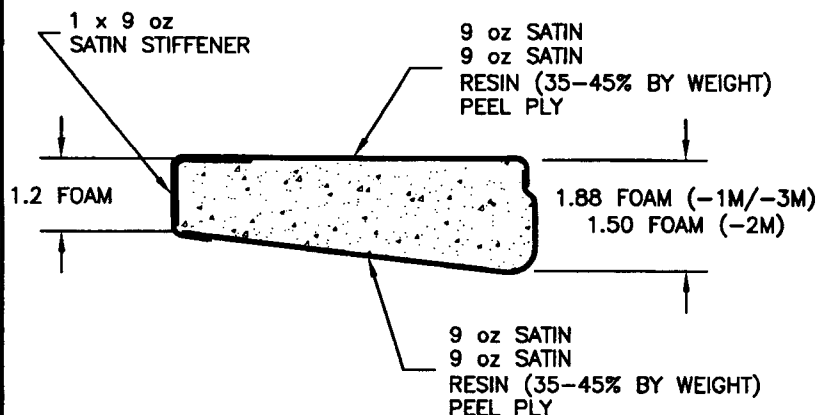
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DATE	07.04.02	DRAWING NO.	D3188		SHEET 4 OF 11
		TITLE	SPACEPOD BODY		SCALE
					NTS

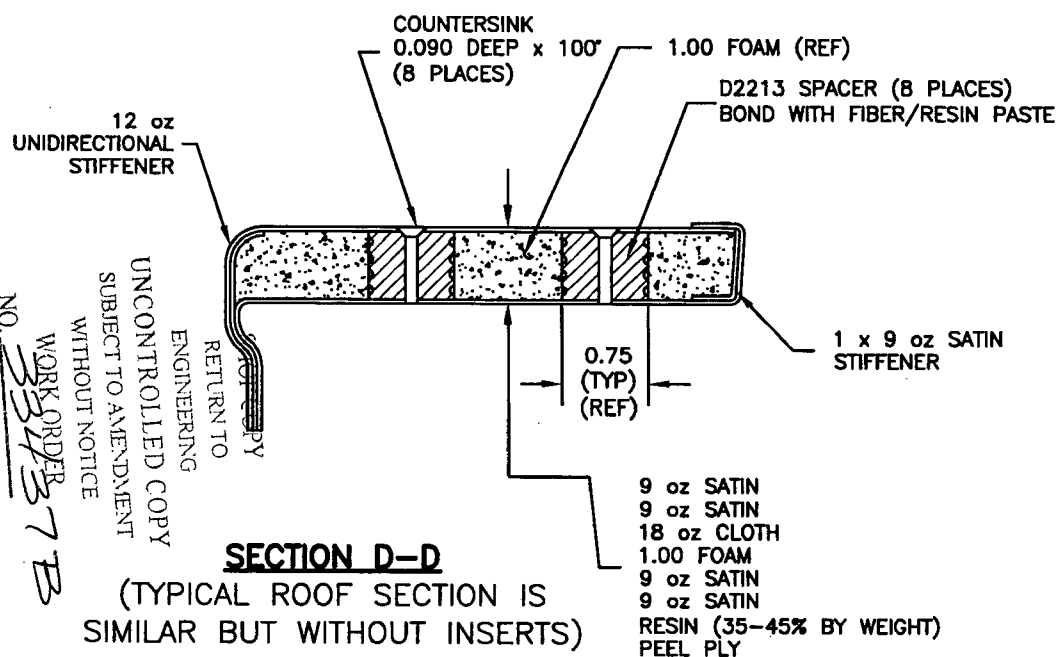
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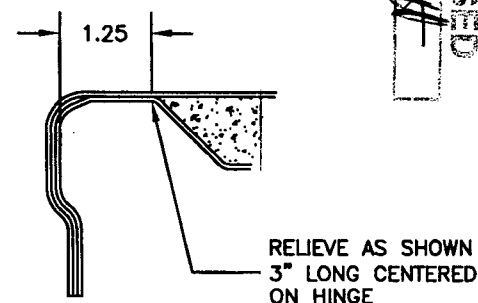
**SECTION B-B**  
(SECTION C-C OPPOSITE)



**SECTION A-A**  
(TYPICAL FLOOR SECTION)



**SECTION D-D**  
(TYPICAL ROOF SECTION IS  
SIMILAR BUT WITHOUT INSERTS)

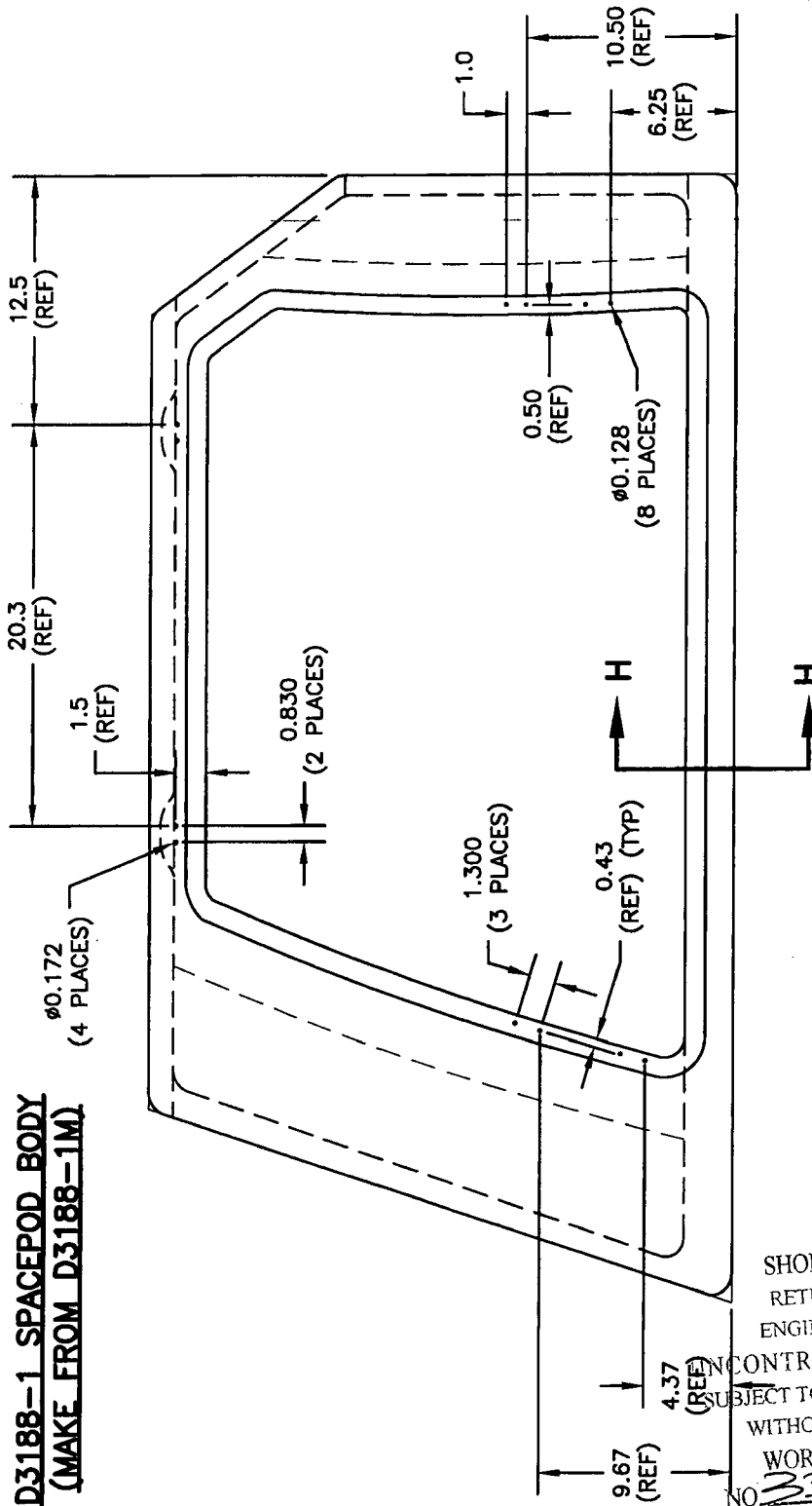
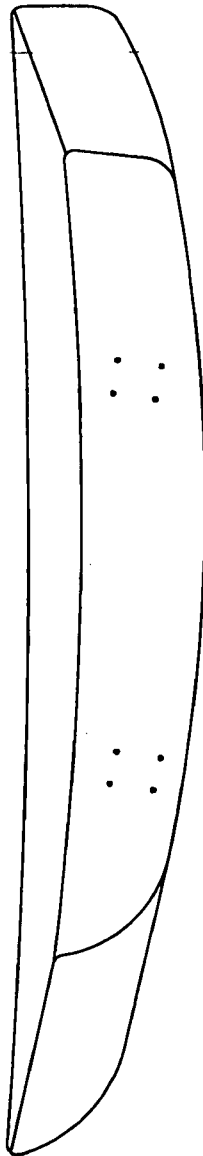


**SECTION E-E**  
(2 PLACES PER POD)



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DATE 07.04.02		TITLE SPACEPOD BODY	SCALE NTS

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07.04.01



**D3188-1 SPACEPOD BODY  
(MAKE FROM D3188-1M)**

- NOTES:**
- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
  - 2) SEE SHEET #11 FOR SECTION VIEW

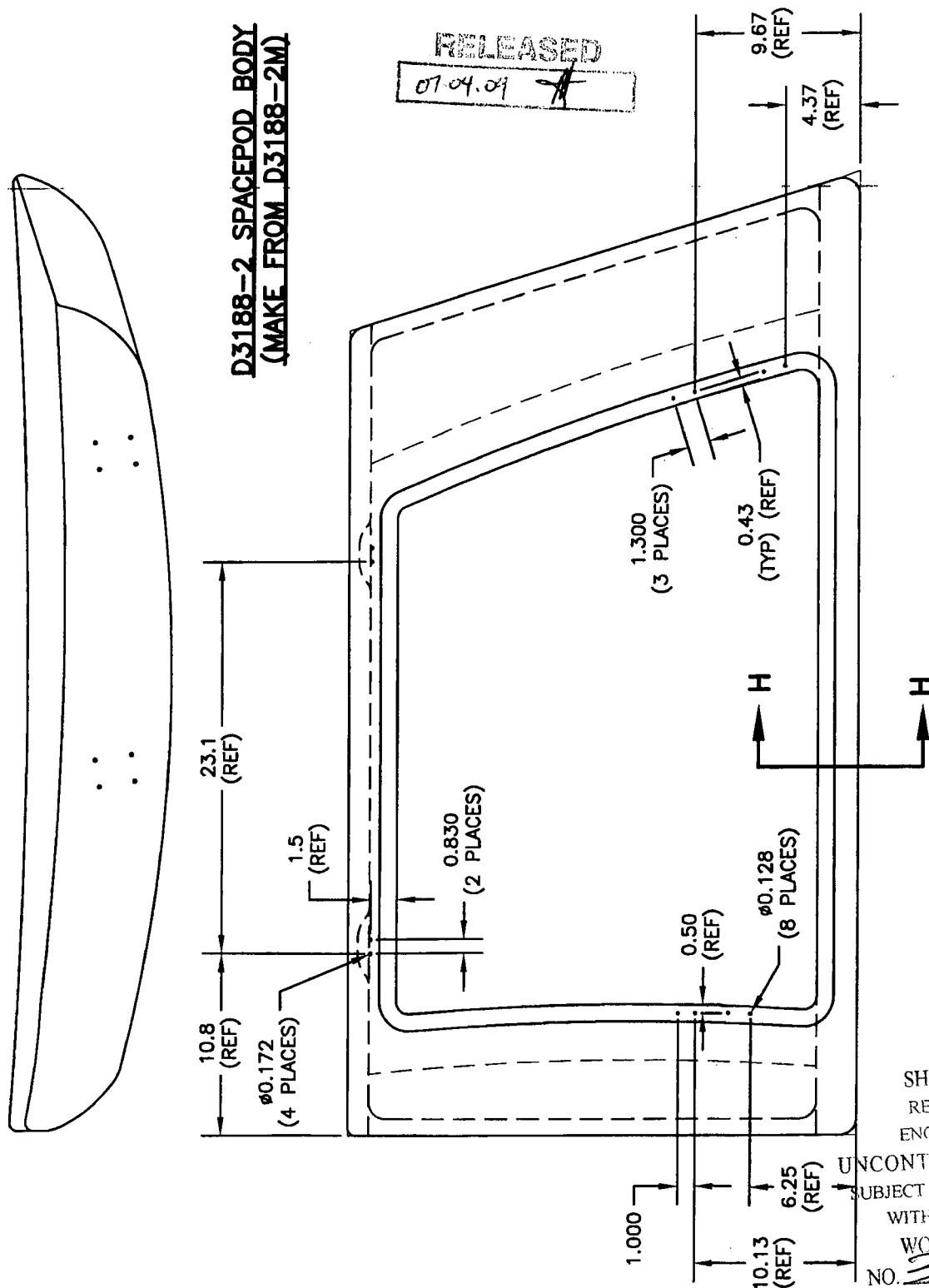
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DATE 07.04.02		TITLE SPACEPOD BODY	SCALE NTS



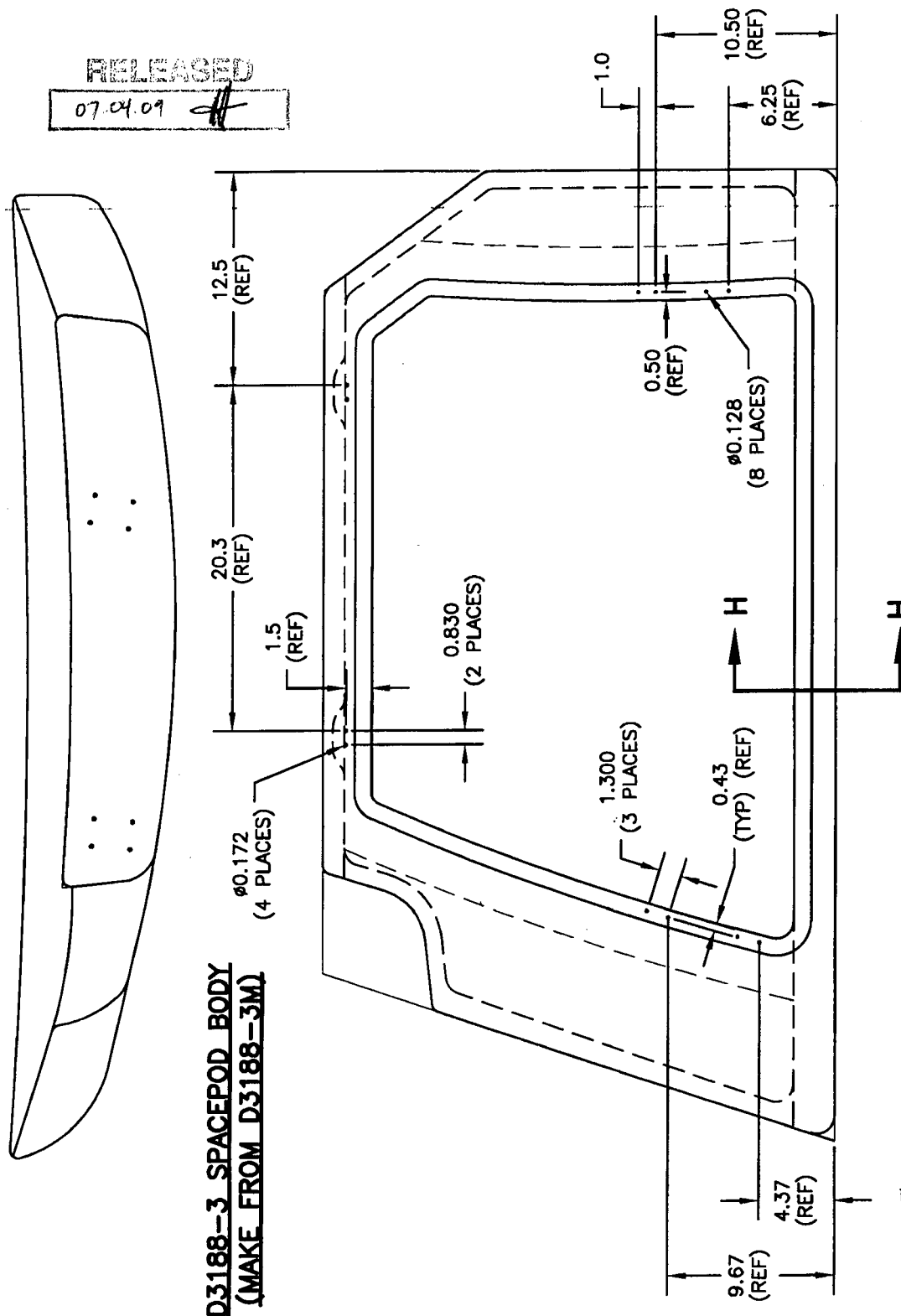
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DATE 07.04.02	TITLE SPACEPOD BODY		SCALE NTS



- NOTES:
- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
  - 2) SEE SHEET #11 FOR SECTION VIEW

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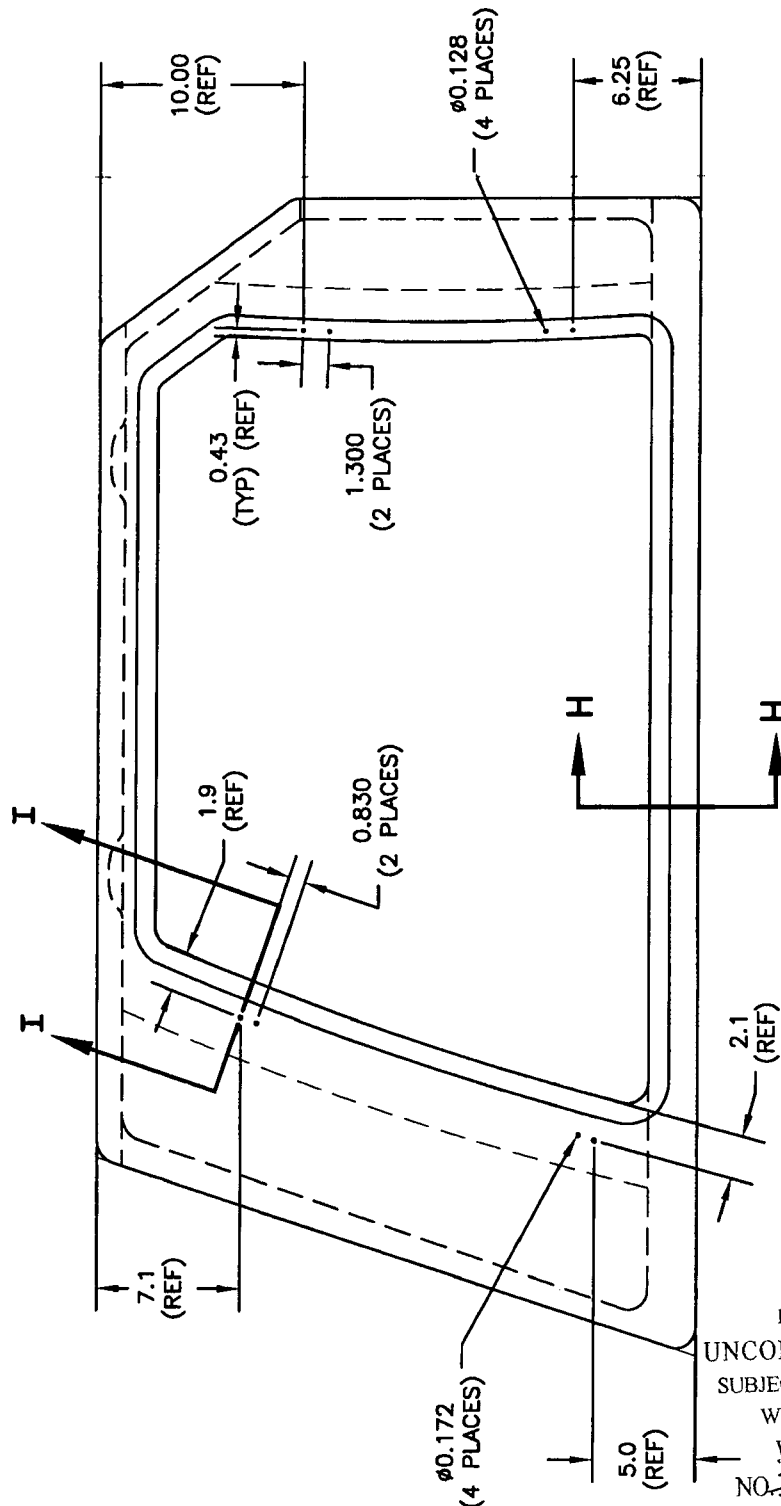
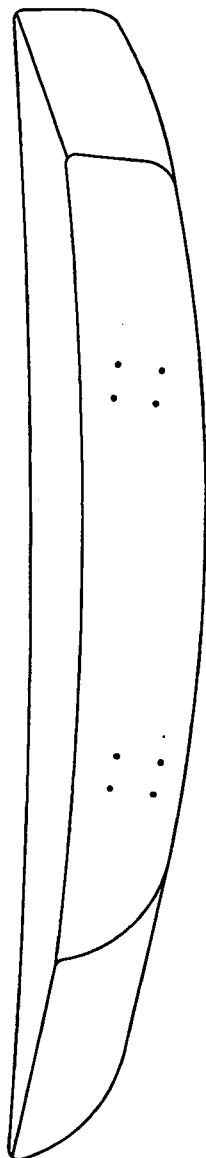


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DATE 07.04.02	TITLE SPACEPOD BODY		SCALE NTS

RELEASED

07.04.02 [Signature]

D3188-5 SPACEPOD BODY  
(MAKE FROM D3188-1M)



NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

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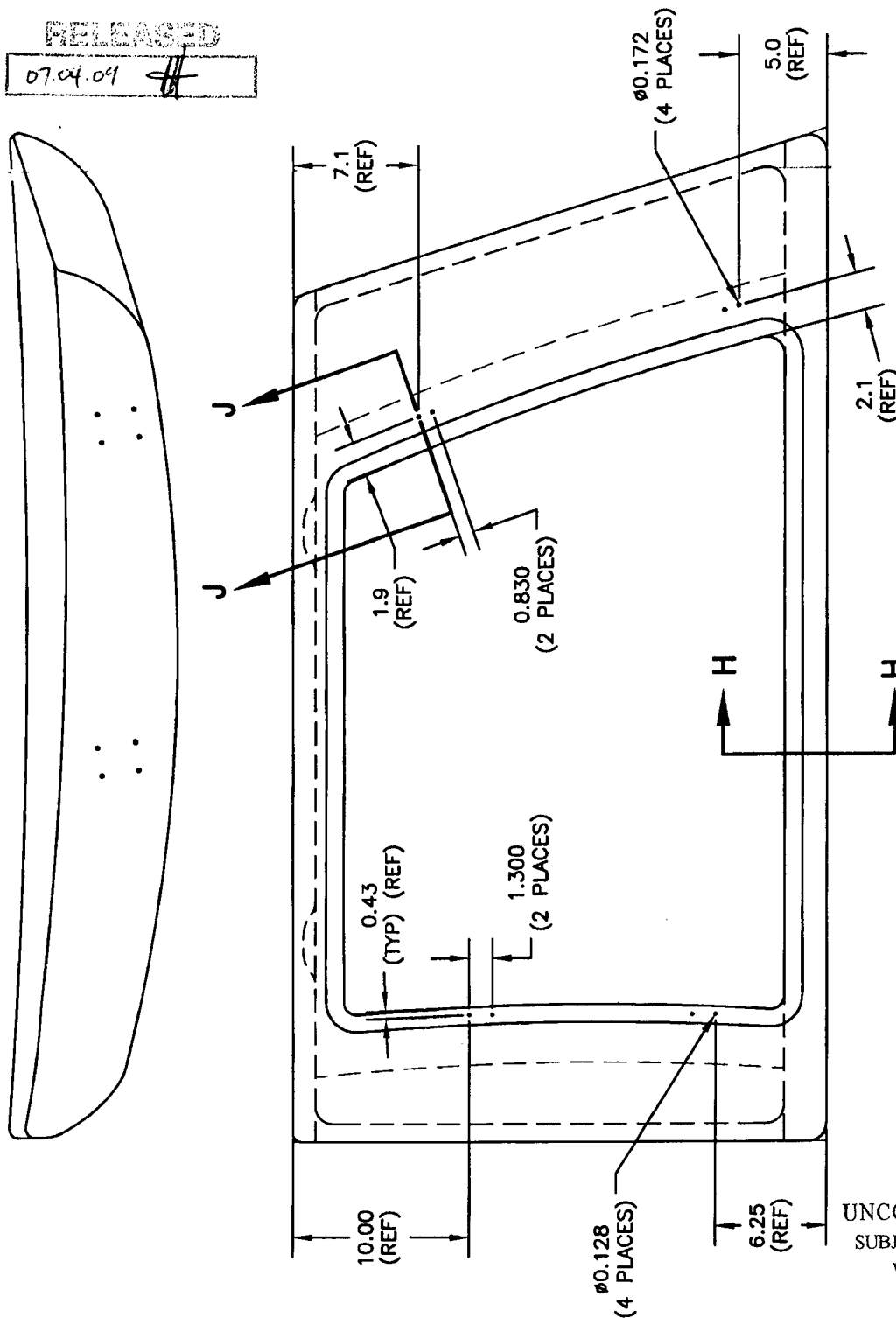
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DATE <b>07.04.02</b>		TITLE <b>SPACEPOD BODY</b>	SCALE NTS

**D3188-6 SPACEPOD BODY**  
**(MAKE FROM D3188-2M)**



**NOTES:**

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-4 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

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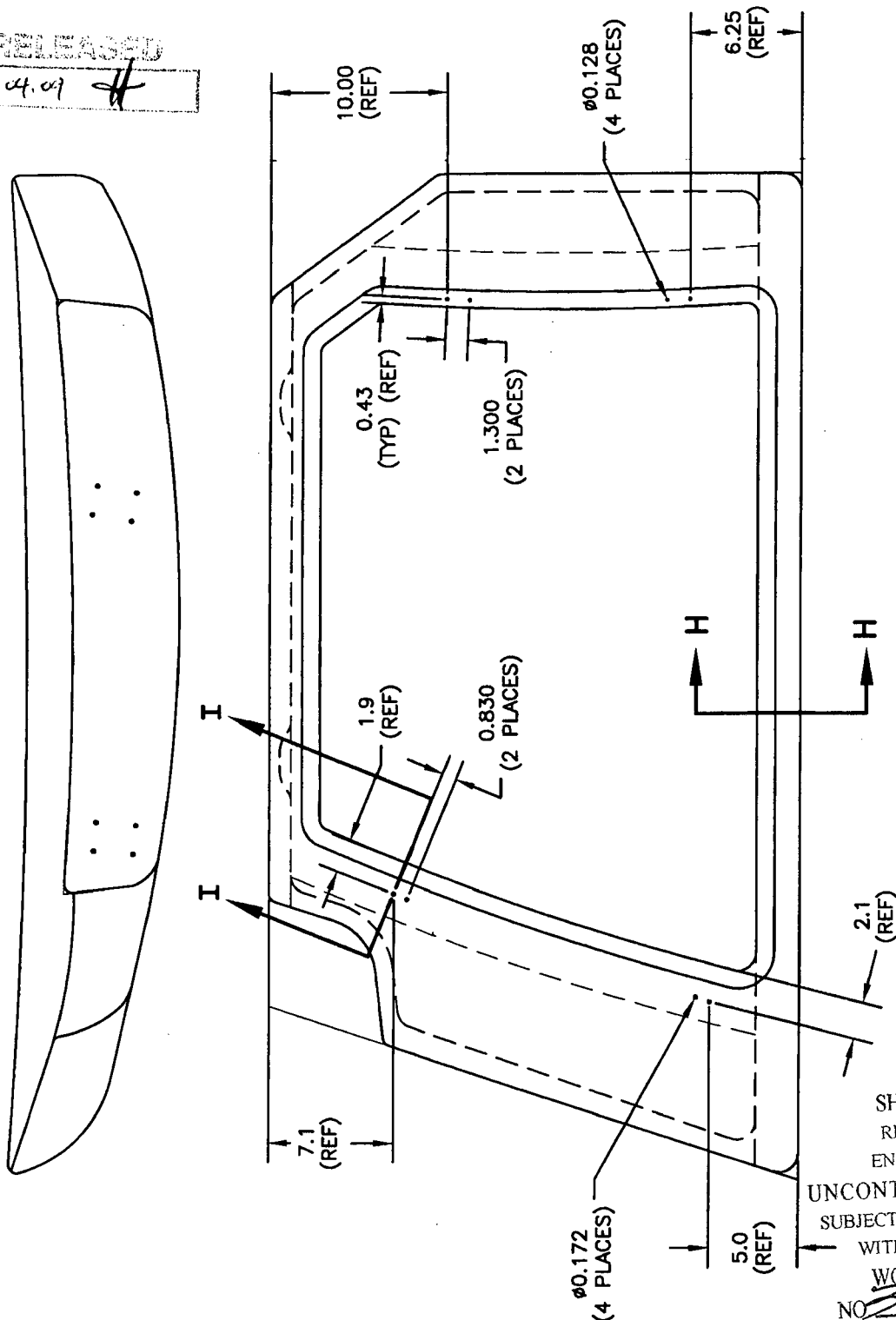
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DATE 07.04.02	TITLE SPACEPOD BODY		SCALE NTS

RELEASED  
07.04.02 [Signature]

**D3188-7 SPACEPOD BODY  
(MAKE FROM D3188-3M)**



NOTE:  
1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE  
TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY  
2) SEE SHEET #111 FOR SECTION VIEWS

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DATE <b>07.04.02</b>		TITLE <b>SPACEPOD BODY</b>	SCALE <b>NTS</b>

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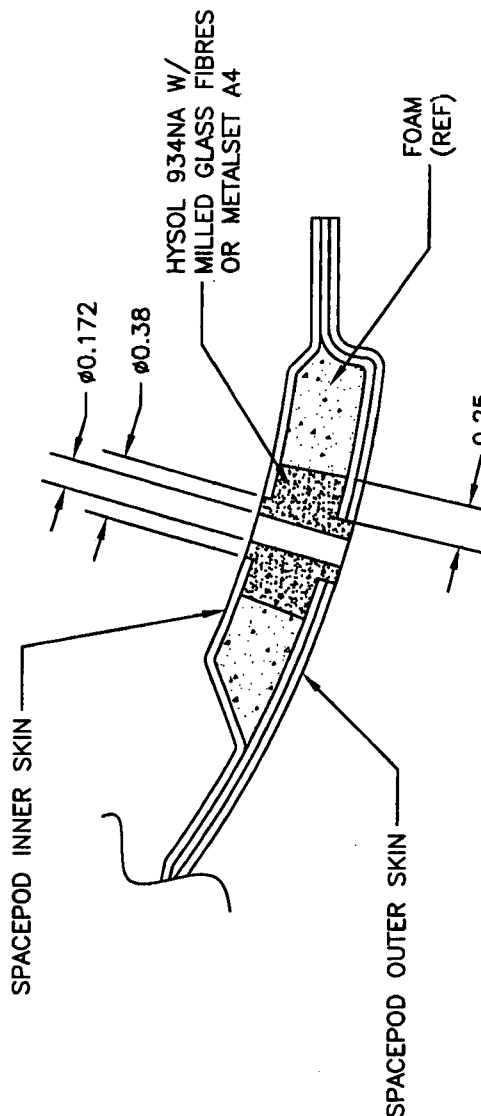
07.04.09

INSTALL AKS7-1032-130  
INSERTS (29 PLACES)  
PER D3188-1T1 (D3188-1/-3/-5/-7)  
OR D3188-2T1 (D3188-2/-6)

FOAM  
(REF)



**SECTION H-H**  
(TYPICAL FLOOR SECTION)



**SECTION I-I**  
(SECTION J-J OPPOSITE)  
(4 PLACES PER POD)

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Date: Monday, 7/9/2007 3:45:58 PM  
 User: Kim Johnston

## Process Sheet

32

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SPACEPOD DOOR RH
Job Number	: 33437C01		
Estimate Number	: 12599		
P.O. Number	: N/A	Part Number	: D31862M
This Issue	: 7/9/2007	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D3186 REV.D
First Issue	: N/A	Project Number	: N/A
Previous Run	: 32706	Drawing Revision	: D
		Material	: N/A
Written By	: <u>[Signature]</u>	Due Date	: 8/5/2007
Checked & Approved By	: <u>[Signature]</u> 07.07.10	Qty:	1 Um: Each
Comment	: Est Rev:A New Issue 06-12-04 ec est rev B rev D dwg 07.03.07 ec		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	PG	PURCHASING
-----	----	------------



Comment: PURCHASING

Issue P/O: 4132 C207/07/01 ①

Description: D3186-2M Door

Supplier: Delastek

Conformity Certificate and Process sheet required

Ship 3 Items from Previous steps

2.0	D31862M	Spacepod Door
-----	---------	---------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
 Spacepod Door

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------

2/9/20 SQ

Comment: PACKAGING RESOURCE #1

Receive and inspect for transit damage. Ensure a copy of certification of conformity and process sheet from  
 Delastek is attached.

4.0	QC6	DIMENSIONAL CHECK
-----	-----	-------------------



Comment: DIMENSIONAL CHECK

Inspect dimensions as per Dwg D3186 .Visual inspection. Check for void spot and pins.

ml 07/10/18

5.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GAml 07/10/18

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: AD Date: 27/11/06  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 7/9/2007 3:45:58 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD DOOR RH

Job Number: 33437C01

Part Number: D31862M

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



②

Comment: FINAL INSPECTION/W/O RELEASE

AP 87.11.06

Job Completion



u 87.11.06



W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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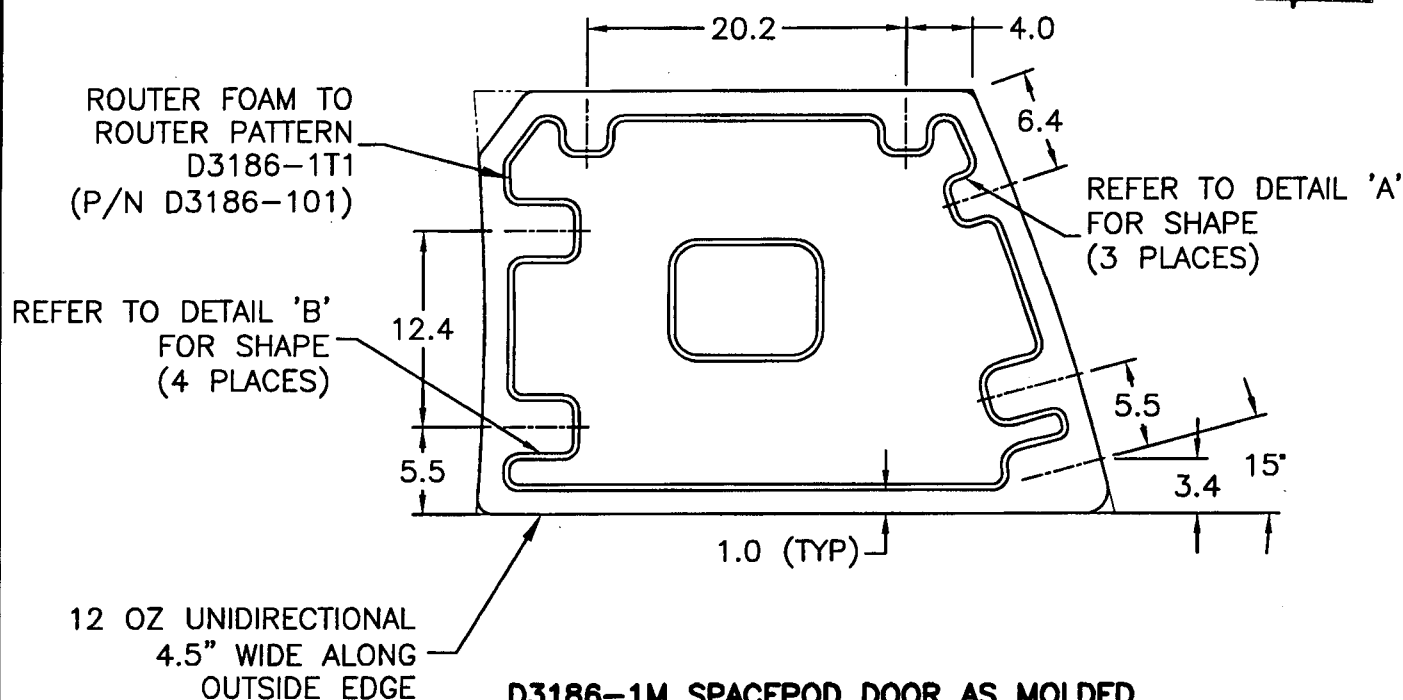
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DATE 07.02.22		TITLE SPACEPOD DOOR	SCALE NTS
A	03.03.27	NEW ISSUE	
B	06.09.25	DIMS UPDATED TO MATCH PRODUCT FOAM PATTERN UPDATED D3186-1M/-2M/-3/-4 ADDED	
C	06.12.13	REMOVED D0600-XXX LABELS	
D	07.02.22	UPDATE DIMENSIONS	

**MAIN LAYUP**

9 OZ SATIN (9 SQ FEET)  
9 OZ SATIN (9 SQ FEET)  
FOAM  
9 OZ SATIN (9 SQ FEET)  
12 OZ UNIDIRECTIONAL  
9 OZ SATIN (9 SQ FEET)  
RESIN (35-45% BY WEIGHT)  
PEEL PLY

**RELEASED**

07.02.27

**D3186-1M SPACEPOD DOOR AS MOLDED****NOTES:**

- 1) USE MOLD DT8005 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYLCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")  
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 8) ALL DIMENSIONS ARE IN INCHES
- 9) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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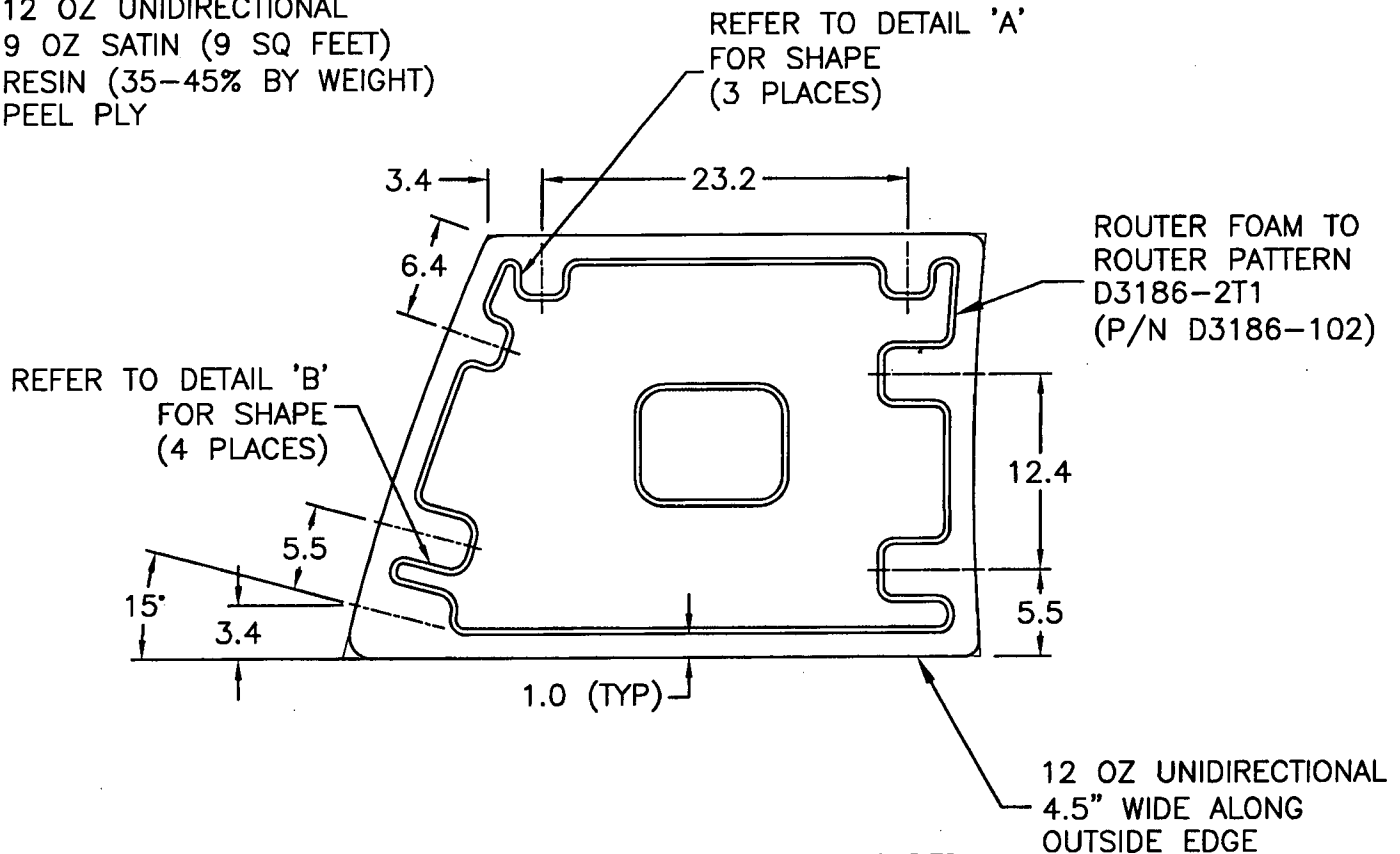
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DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS

**MAIN LAYUP**

9 OZ SATIN (9 SQ FEET)  
9 OZ SATIN (9 SQ FEET)  
FOAM  
9 OZ SATIN (9 SQ FEET)  
12 OZ UNIDIRECTIONAL  
9 OZ SATIN (9 SQ FEET)  
RESIN (35-45% BY WEIGHT)  
PEEL PLY

**RELEASED**

07.02.27 H

**D3186-2M SPACEPOD DOOR AS MOLDED****NOTES:**

- 1) USE MOLD DT8006 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")  
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 8) ALL DIMENSIONS ARE IN INCHES
- 9) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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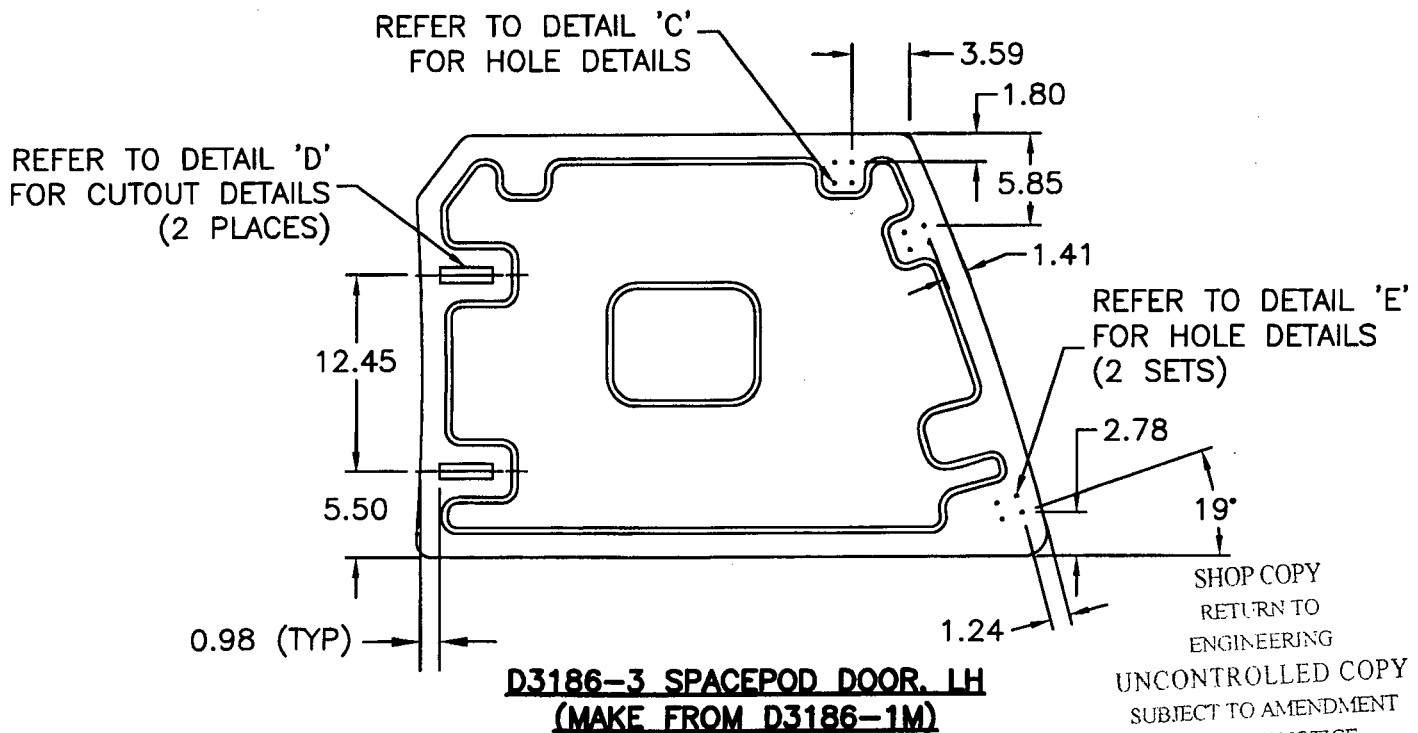
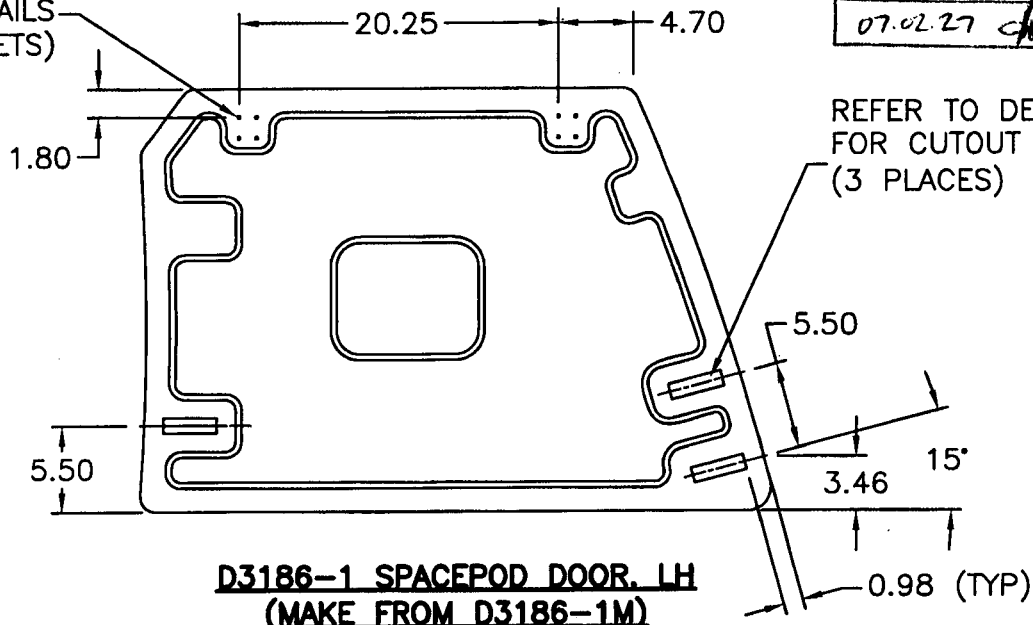
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DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS

REFER TO DETAIL 'C'  
FOR HOLE DETAILS  
(2 SETS)

**NOTES:**

- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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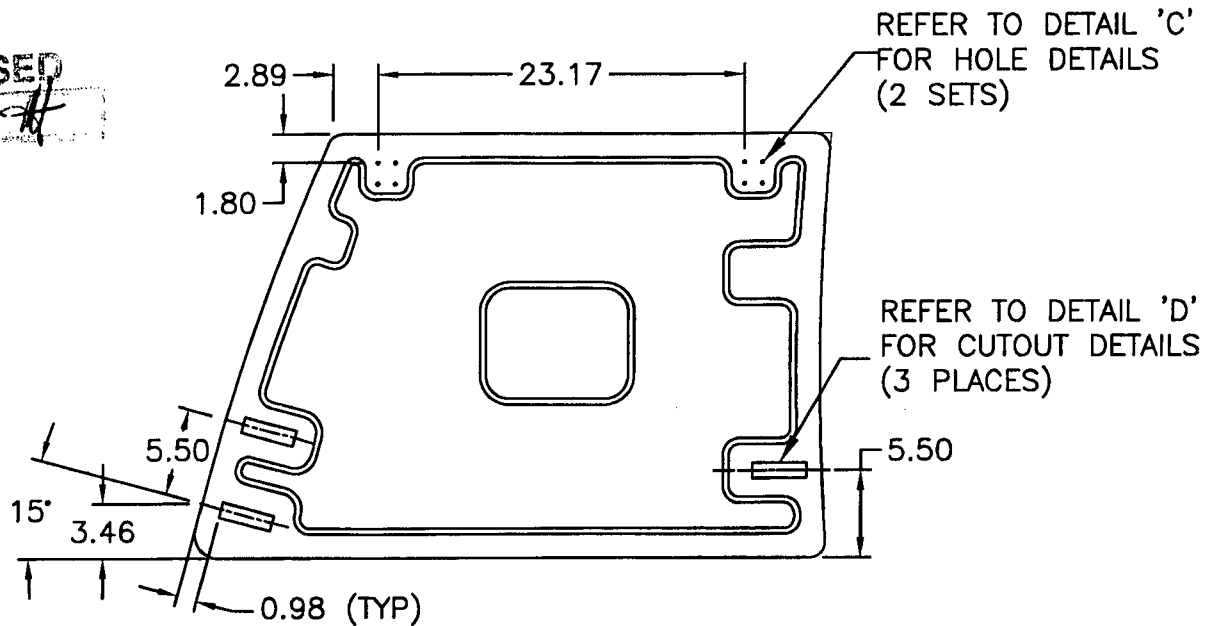
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**DART**

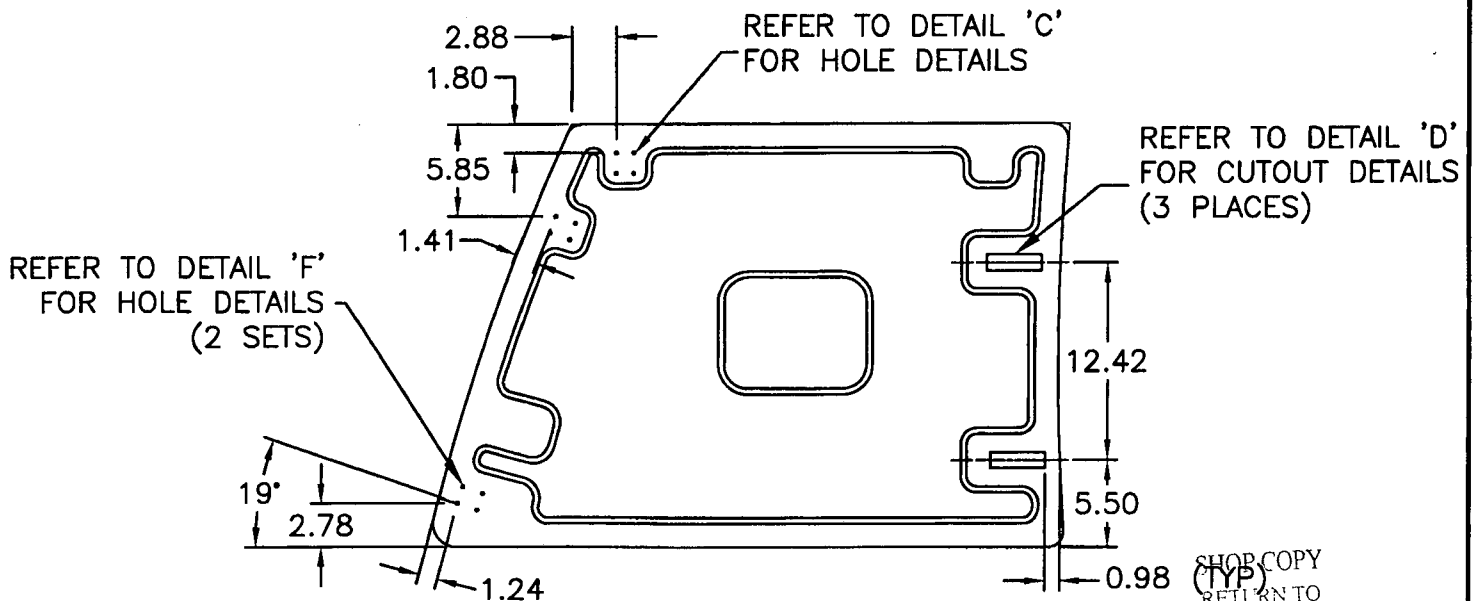
DESIGN DS	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3186	REV. D SHEET 4 OF 5
DATE 07.02.22		TITLE SPACEPOD DOOR	SCALE NTS

**RELEASED**

07-02-27



**D3186-2 SPACEPOD DOOR. RH**  
**(MAKE FROM D3186-2M)**



**D3186-4 SPACEPOD DOOR. RH**  
**(MAKE FROM D3186-2M)**

**NOTES:**

- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

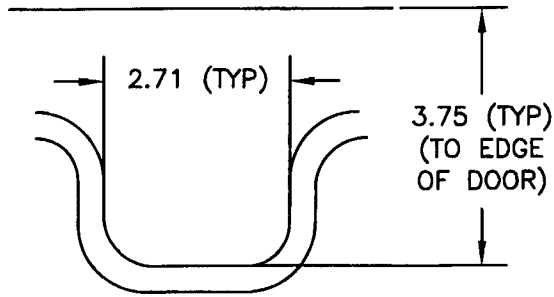
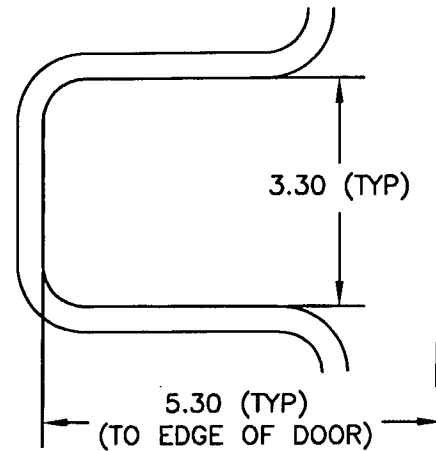
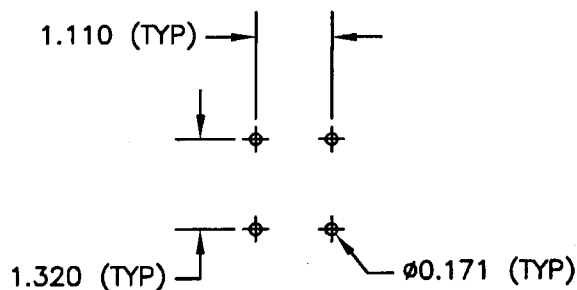
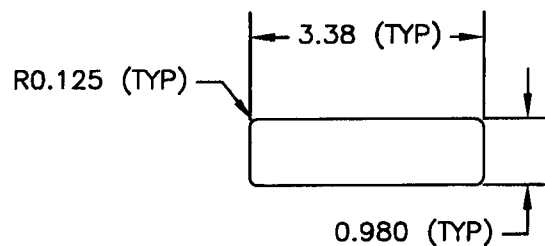
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UNCONTROLLED COPY  
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WITHOUT NOTICE  
WORK ORDER  
NO. 33437001

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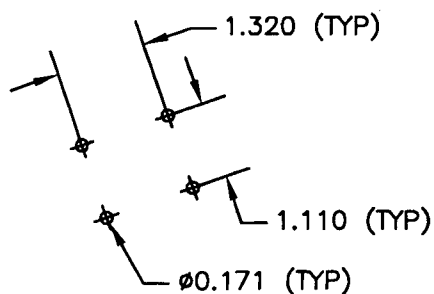
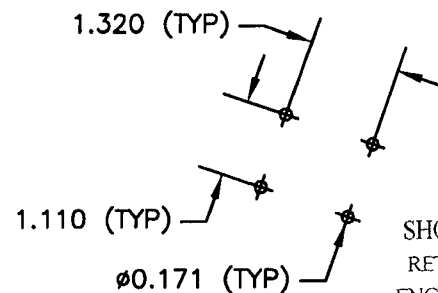
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**DART**

DESIGN DS	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3186	REV. D SHEET 5 OF 5
DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS

**DETAIL A****DETAIL B****RELEASED**07.02.27 *[Signature]***DETAIL C**

NOTE: ENSURE THAT CUTOUT IS PERPENDICULAR TO EDGE OF DOOR

**DETAIL D****DETAIL E****DETAIL F**SHOP COPY  
RETURN TO  
ENGINEERINGUNCONTROLLED COPY  
SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 33437001

**NOTES:**

- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DELASTEK COMPOSITES INC.  
2699, 5ième Avenue  
Local 14, PORTE -A-  
Grand-Mère, Québec G9T 5K7  
Can \*\*Fax (819) 533-3494 \*\*

# PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice #	12164
Customer #	DART

Telephone: (819) 533-5788

V/arehouse: MAIN

Dart Aerospace Ltd.  
1270, Aberdeen Street  
Hawkesbury, Ontario K6A 1K7  
Canada

Telephone: 613-632-5200

Contact: Linda Lacelle

Bill to:

Ship to:

Dart Aerospace Ltd.  
1270, Aberdeen Street  
Hawkesbury, Ontario K6A 1K7  
Canada

Ship via		F.O.B.		Terms		Salesperson	
EPIC EXPRESS COLLECT		Origin		Net30 days		Claude Lessard, ext. 233	
Ship date	Order Date	Our PO #	Order by	Your PO #		GST/PST #	
19/09/2007	10/07/2007	5416	Chantal Lavoie	PO00004132			
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description			
1	0	✓ 1	DKC134-0052	D31861M Spacepod Door LH B33438B01 Dwg. Rév.: D Job: 41397 U de M : Each			
1	0	✓ 1	DKC134-0053	D31881M Spacepod Body LH B33438A Dwg. Rév.: D Job: 42032 U de M : Each			
1	0	✓ 1	DKC134-0054	D31862M Spacepod Door RH B33437C01 Dwg. Rév.: D Job: 42033 U de M : Each			
1	0	✓ 1	DKC134-0055	D31882M Spacepod Body RH B33437B Dwg. Rév.: D Job: 42035 U de M : Each			

4/9/20  
SG

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

Accepted by:

*[Signature]*

Quality department

AQ-357


☒ Cust. ☐ Adm. ☐ Quality ☐ Ship.



Date: Lundi, 2007-08-20 11:18:07  
 Utilisateur: Marc Dubé

## Feuille de Procédé

Client	: DART	Dart Aerospace Ltd.	Nom Dessin	: SPACEPOD DOOR	
Numéro Job	: 42033		Numéro Article	: DKC134-0054	
Numéro Soumission	: 2586		Numéro Dessin	: D3186	
Numéro B.A.	:		Projet Numéro	: DKC134	
Cette fois	: 2007-08-20	No. B.V. :	Révision dessin	: C	
Prsht Rev.	: NC		Matériel	: Fibre 7781 et Résine 411-350	
Prem. fois	: - -	Type :	Date Dûe	: 2007-08-27	Qté: 1 Udm: UNITE
Job précédente	: 42018				



Écrit par : \_\_\_\_\_  
 Vérifié & Approuvé par : \_\_\_\_\_  
 Commentaires : N° de pièce Dart Aerospace : D31862M

Process Sheet Rev.: 02 Ajouter une séquence d'emballage et une séquence d'inspection du positionnement de foam Core

## Produit additionnel

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
---------	-----------------------	---------------

1.0	AC0303	Frekote 44NC
-----	--------	--------------


Commentair Qty.:	0.020 GALLON(s)/Unit	Total :	0.020 GALLON(s)
	Frekote 44NC		

2.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
-----	---------------	------------------------------



Commentair	Setup: 0.00Hrs/ Run: 5.0000Min	Total Run : 0.0833Hrs
	PRÉPARATION DU MOULE	

Faire la préparation du moule N° DT 8005 à l'aide de Frekote 44NC et laisser sécher pendant 3 heures selon le QSI-006.

 Date: AUG 21 2007 Heure Début: 8:00 Heure Fin: 12:00 Sceau: 

3.0	AC0409	Tissu à délaminer Release ply B
-----	--------	---------------------------------

Commentair Qty.:	3.28 VERGE(s)/Unit	Total :	3.28 VERGE(s)
	Tissu à délaminer Release ply B		

4.0	AC0407	Wrightlon 5200 Bleu P3
-----	--------	------------------------

Commentair Qty.:	3.59 VERGE(s)/Unit	Total :	3.59 VERGE(s)
	Wrightlon 5200 Bleu P3		

5.0	AC0408	Feutre de drainage N° Airweave N 10
-----	--------	-------------------------------------

Commentair Qty.:	3.00 VERGE(s)/Unit	Total :	3.00 VERGE(s)
	Feutre de drainage N° Airweave N 10		

6.0	AC0752	Stretchlon 200 poche à vide Vert
-----	--------	----------------------------------

Commentair Qty.:	3.00 VERGE(s)/Unit	Total :	3.00 VERGE(s)
	Stretchlon 200 poche à vide Vert		



## Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD DOOR

Numéro Job: 42033

Numéro Article: DKC134-0054

Numéro Job:



# Séq.: Machine ou Opération: Description :

7.0 AAC0681 9.7 oz Weave #FG-778150-125Y Volan Finish

Commentair Qty.: 4.500 VERGE(s)/Unit Total: 4.500 VERGE(s)

9.7 oz Weave #FG-778150-125Y Volan Finish

# LOT: 2-6093-1

8.0 AAC0443 Fiberglass 12 oz Unidirectional

Commentair Qty.: 1.00 VERGE CAR(s)/Unit Total: 1.00 VERGE CAR(s)

Fiberglass 12 oz Unidirectional

N° de Lot:

1-5964-1

9.0 AC0098 Ruban à gommer jaune #: T/AT-200Y

Commentair Qty.: 2.2500 RL(s)/Unit Total: 2.2500 RL(s)

Ruban à gommer jaune #: T/AT-200Y

10.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run: 0.5000Hrs

TAILLAGE DU MATÉRIEL

Tailler le matériel, selon les différents patrons de découpe:

Appliquer le Ruban jaune tout le tour du stretchlon 200 en laissant le papier sur le coté non en contact avec le sac à vide.

À fin d'accélérer le processus de taillage, tailler les plis de 9.7 oz tous en même temps en les superposants les uns sur les autres.

Date: 6/07/07 Heure Début: 7:30 Heure Fin: 12:00 Sceau:



11.0 AAC0275 Catalyst N° DDM-9

Commentair Qty.: 0.0640 PINTE(s)/Unit Total: 0.0640 PINTE(s)

Catalyst N° DDM-9

N° de Lot:

1-6118-3

12.0 AAC0324 Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.500 KILOGRAMME(s)/Unit Total: 0.500 KILOGRAMME(s)

Résine (411B7530) 411-350 promo. 75min

N° de Lot:

1-6271-1

13.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run: 0.0833Hrs

PRÉPARATION DU MATÉRIEL










Faire la préparation de la résine selon les quantité requises, mix ration 1.5% de Catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: AUG 22 2007 Heure Début: 7:30 Heure Fin: 7:35 Sceau:













Date: Lundi, 2007-08-20 11:18:07  
Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.		Nom Dessin: SPACEPOD DOOR	
Numéro Job: 42033		Numéro Article: DKC134-0054	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
14.0	LAMINAGE.	LAMINAGE PIÈCE DART	
			
<b>Commentaire</b> Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs FAIRE LE LAMINAGE DES TISSUS  À l'aide d'un rouleau 2" dia. appliquer une couche de résine N° 411-350 sur le moule N° DT 8004 et ensuite imbiber un pli de tissu 9.7oz.  Recommencer l'opération pour le deuxième pli. Date: <u>AUG 22 2007</u> Heure Début: <u>7:35</u> Heure Fin: <u>7:50</u> Sceau:  			
15.0	POCHE À VIDE 1	FAIRE LA POCHE À VIDE	
			
<b>Commentaire</b> Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs EFFECTUER LA POCHE A VIDE  Faire la poche à vide en appliquant les composantes dans l'ordre suivant:  1- Tissu à délaminer, 2- Film perforé P-3, 3- Feutre de drainage 4- Sac à vide Stretchlon 200  Laisser sécher pendant 4 heures minimum. Date: <u>AUG 22 2007</u> Heure Début: <u>7:50</u> Heure Fin: <u>8:00</u> Sceau:   Curing Début: <u>7:35</u> Curing Fin: <u>12:30</u>			
16.0	AAC0275	Catalyst N° DDM-9	
<b>Commentaire</b> Qty.: 0.0120 PINTE(s)/Unit Total : 0.0120 PINTE(s) Catalyst N° DDM-9 N° de Lot: <u>1-6118-3</u>			
17.0	AAC0324	Résine (411B7530) 411-350 promo. 75min.	
<b>Commentaire</b> Qty.: 0.300 KILOGRAMME(s)/Unit Total : 0.300 KILOGRAMME(s) Résine (411B7530) 411-350 promo. 75min. N° de Lot: <u>1-6271-1</u>			

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.		Nom Dessin: SPACEPOD DOOR	
Numéro Job: 42033		Numéro Article: DKC134-0054	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
18.0	PRÉPARATION 3 	PRÉPARATION DU MATÉRIEL DART 	
<p>Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs PRÉPARATION DU MATÉRIEL</p> <p>Faire la préparation de la résine selon les quantité requises, mix ration 1.5% de Catalyst N° DDM-9 par quantité de résine N° 411-350 Imbiber toutes les surfaces du foam core.</p> <p>Laisse sécher pendant 2 heure.</p> <p>Date: <u>AUG 23 2007</u> Heure Début: <u>9:00</u> Heure Fin: <u>9:15</u> Sceau:  </p>			
19.0	AAC0452	Polybond B46F	
<p>Commentaire Qty.: 0.082 KIT(s)/Unit Total : 0.082 KIT(s) Polybond B46F N° de Lot: <u>1-6177-1</u></p>			
20.0	DKC134-0057	Foam Core N° D3186-102 ( Porte D3186-2 )	
<p>Commentaire Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s) Foam Core N° D3186-102 ( Porte D3186-2 )</p> <p>N° de Job: <u>42017</u></p>			
21.0	ASSEMBLAGE 3 	ASSEMBLAGE GÉNÉRALE DART 	
<p>Commentaire Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs ASSEMBLAGE GÉNÉRALE DES PIÉCES</p> <p>Retirez le bagging.</p> <p>Pour aider au positionnement du 12 oz., positionner le gabarit de trimage dans le moule et tracer son contour sur le 9 oz.. Retirer le gabarit de trimage .</p> <p>Positionner le foam core à l'aide du gabarit prévu à cet effet et tracer son contour sur le 9 oz. ( Vous devriez maintenant avoir 2 contours de tracé sur le 9 oz. )</p> <p>Faire l'inspection du positionnement par le département de la qualité</p> <p>Date: _____ Sceau: _____ Initiales: _____ <u>N/A</u>  <u>23-08-07 NS.</u></p> <p>Appliquer une couche de Polybond B64F à l'endos du Foam Core N° DKC134-0057 et positionner le foam Core sur le moule selon le dessin, et selon les ligne de positionnement prévues à cet effet.</p> <p>Date: <u>AUG 23 2007</u> Heure Début: <u>1:00</u> Heure Fin: <u>1:15</u> Sceau:  </p>			

ate: .. Lundi, 2007-08-20 11:18:07  
tilisateur: Marc Dubé

## Feuille de Procédé

Cliant: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD DOOR

Numéro Job: 42033

Numéro Article: DKC134-0054

Numéro Job:



# Séq.: Machine ou Opération: Description :

22.0

POCHE À VIDE 1

FAIRE LA POCHE À VIDE



Commentaire Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

EFFECTUER LA POCHE A VIDE



Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Tissu à délaminer
- 2- Feutre de drainage
- 3- Sac à vide Stretchlon 200

Laisser sécher pendant 2 heures minimum.

Retirez le bagging avant la fin de la polymérisation ( entre 1 heure et 1heure 1/2 ) afin d'enlever le surplus de polybond

Date: AUG 23 2007

Heure Début: 1:15 Heure Fin: 1:30 Sceau:  

Curing Début: 1:00 Curing Fin: 2:15

23.0

AAC0275

Catalyst N° DDM-9

Commentaire Qty.: 0.0400 PINTE(s)/Unit Total : 0.0400 PINTE(s)

Catalyst N° DDM-9

N° de Lot: 1-6118-3

24.0

AAC0324

Résine (411B7530) 411-350 promo. 75min.

Commentaire Qty.: 1.000 KILOGRAMME(s)/Unit Total : 1.000 KILOGRAMME(s)

Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-6271-1

25.0

PRÉPARATION 3

PRÉPARATION DU MATÉRIEL DART





Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantité requises, mix ration 1.5% de Catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: AUG 28 2007

Heure Début: 10:25 Heure Fin: 10:30 Sceau:  

Date: Lundi, 2007-08-20 11:18:08  
Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.  
Numéro Job: 42033

Nom Dessin: SPACEPOD DOOR  
Numéro Article: DKC134-0054

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
---------	-----------------------	---------------

29.0	TRIMAGE 3	TRIMAGE COMPOSITES DART
------	-----------	-------------------------



Commentaire Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs  
TRIMAGE DE FINITION

Trimer les contour de la pièce l'aide du gabarit de trimage prévu à cet effet.

Date: AUG 29 2007 Heure Début: 10:20 Heure Fin: 10:40 Sceau:

30.0	AAC0671	Dupont Primer N° 1104S
------	---------	------------------------

Commentaire Qty.: 0.1390 GALLON(s)/Unit Total : 0.1390 GALLON(s)  
Dupont Primer N° 1104S

N° de Lot: 1-6282-1

31.0	AAC0670	Dupont Activator N° 7975S
------	---------	---------------------------

Commentaire Qty.: 0.2800 PINTE(s)/Unit Total : 0.2800 PINTE(s)  
Dupont Activator N° 7975S

N° de Lot: 1-6254-1

32.0	AAC0672	Dupont Reducer N° 12375S
------	---------	--------------------------

Commentaire Qty.: 0.0350 GALLON(s)/Unit Total : 0.0350 GALLON(s)  
Dupont Reducer N° 12375S

N° de Lot: 1-5769-3

33.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
------	---------------	------------------------------



Commentaire Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs  
PRÉPARATION DU MATÉRIEL DART

Bien brasser les trois contenants servant à faire le mélange du primer gris N° 1104S et ensuite faire le mélange selon les instruction du fabriquant.

34.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
------	---------------	------------------------------



Commentaire Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs  
PRÉPARATION DU MATÉRIEL DART

Appliquer une première couche de primer Dupont N° 1104S ( 7975S Activator, 12375S Reducer.) Selon I.G.  
# Application primer

Laisser sécher pendant 3 heures.

## Feuille de Procédé

Cliant: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD DOOR

Numéro Job: 42033

Numéro Article: DKC134-0054

Numéro Job:



# Séq.: Machine ou Opération: Description :

Date: 31-8-07 Heure Début: 10:15 Heure Fin: 11:30 Sceau: 

35.0

FINITION 3

FINITION PIÈCE DART



Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs  
FINITION PIÈCE DART

Faire le sablage de la pièce à l'aide de papier sablé grit 220 afin de corriger les imperfection et enlever le lustre du primer.

36.0

AC0058

Polysoft 1.3 kg # 003012 Sikkens

Commentaire Qty.: 0.050 UNITE(s)/Unit Total : 0.050 UNITE(s)  
Polysoft 1.3 kg # 003012 Sikkens

N° de Lot: 1-6227-1

37.0

AC0059

Durcisseur Polysoft #004009 Sikkens

Commentaire Qty.: 0.039 UNITE(s)/Unit Total : 0.039 UNITE(s)  
Durcisseur Polysoft #004009 Sikkens

38.0


FINITION 3

FINITION PIÈCE DART



Commentaire Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs  
FINITION GÉNÉRALE

Faire les réparations de finition s'il y a lieu, à l'aide de Sikkens.

Date: 04-9-07 Heure Début: 10:15 Heure Fin: 11:45 Sceau: 

39.0

AAC0671

Dupont Primer N° 1104S

Commentaire Qty.: 0.1390 GALLON(s)/Unit Total : 0.1390 GALLON(s)  
Dupont Primer N° 1104S N° de Lot: 1-6282-1

40.0

AAC0670

Dupont Activator N° 7975S

Commentaire Qty.: 0.2800 PINTE(s)/Unit Total : 0.2800 PINTE(s)  
Dupont Activator N° 7975S N° de Lot: 1-6254-1

41.0

AAC0672

Dupont Reducer N° 12375S

Commentaire Qty.: 0.0350 GALLON(s)/Unit Total : 0.0350 GALLON(s)  
Dupont Reducer N° 12375S N° de Lot: 1-5769-83

42.0

PRÉPARATION 3

PRÉPARATION DU MATÉRIEL DART



Commentaire Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs  
PRÉPARATION DU MATÉRIEL

Bien brasser les trois contenants servant à faire le mélange du primer gris N° 1104S et ensuite faire le mélange selon les instruction du fabriquant.

Date: Lundi, 2007-08-20 11:18:08  
Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD DOOR

Numéro Job: 42033

Numéro Article: DKC134-0054

Numéro Job:



# Séq.:

Machine ou Opération:

Description :

43.0

PRÉPARATION 3

PRÉPARATION DU MATÉRIEL DART



Commentaire Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs  
APPLICATION DE PRIMER

Appliquer une deuxième couche de primer Dupont N° 1104S ( 7975S Activator, 12375S Reducer ) Selon I.G.  
# Application de primer.

Date: 05-09-07 Heure Début: 10:15 Heure Fin: 10:45 Sceau:

44.0

INSPECTION 3

INSPECTION PIÈCE DART



Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs  
INSPECTION PIÈCE DART

Inspection des pièces par le département de la qualité

Quantité: 1

Date: 11-9-07

Sceau:

Quantité: \_\_\_\_\_

Date: \_\_\_\_\_

Sceau: \_\_\_\_\_

45.0

EMBALLAGE

EMBALLAGE ET ENTREPOSAGE



Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs  
EMBALLAGE ET ENTREPOSAGE

Faire l'emballage des pièces.

Quantité: 1

Date: 11 sept 07

Sceau:

Quantité: \_\_\_\_\_

Date: \_\_\_\_\_

Sceau: \_\_\_\_\_



DELASTEK COMPOSITES INC.  
2699, 5ième Avenue  
Local 14, PORTE -A-  
Grand-Mère, Québec G9T 5K7  
Can \*\*Fax (819) 533-3494 \*\*

# PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice #	12164
Customer #	DART

Telephone: (819) 533-5788

Warehouse: MAIN

Bill to:

Dart Aerospace Ltd.  
1270, Aberdeen Street  
Hawkesbury, Ontario K6A 1K7  
Canada

Ship to:

Dart Aerospace Ltd.  
1270, Aberdeen Street  
Hawkesbury, Ontario K6A 1K7  
Canada

Telephone: 613-632-5200

Contact: Linda Lacelle

Ship via		F.O.B.		Terms		Salesperson	
EPIC EXPRESS COLLECT		Origin		Net30 days		Claude Lessard, ext. 233	
Ship date	Order Date	Our PO #	Order by		Your PO #	GST/PST #	
19/09/2007	10/07/2007	5416	Chantal Lavoie		PO00004132		
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description			
1	0	/ 1	DKC134-0052	D31861M Spacepod Door LH B33438B01 Dwg. Rév.: D Job: 41397 U de M : Each			
1	0	✓ 1	DKC134-0053	D31881M Spacepod Body LH B33438A Dwg. Rév.: D Job: 42032 U de M : Each			
1	0	✓ 1	DKC134-0054	D31862M Spacepod Door RH B33437C01 Dwg. Rév.: D Job: 42033 U de M : Each			
1	0	✓ 1	DKC134-0055	D31882M Spacepod Body RH B33437B Dwg. Rév.: D Job: 42035 U de M : Each			

7/9/20  
SS

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

☒ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Accepted by:

*[Signature]*

Quality department

AQ-357





## Feuille de Procédé

Client :	DART Dart Aerospace Ltd.	Nom Dessin :	SPACEPOD BODY R/H
Numéro Job :	42035	Numéro Article :	DKC134-0055
Numéro Soumission :	2587	Numéro Dessin :	D3188
Numéro B.A. :		Projet Numéro :	DKC134
Cette fois :	2007-08-20 No. B.V. :	Révision dessin :	E
Proch. Rev. :	NC	Matériel :	Fibre 7781 et Résine 411-350
Rem. fois :	-- Type :	Date Dûe :	2007-08-27 Qté: 1 Udm: UNITE
Job précédente :	41616		
Écrit par :			
Vérifié & Approuvé par :			
Commentaires :	N° de pièce Dart Aerospace : D31882M		



Process Sheet Rev.: 03 Changer la révision de dessin de C @ E

### Produit additionnel

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
1.0	AC0303	Frekote 44NC
Commentaire Qty.: 0.050 UNITE(s)/Unit Total : 0.050 UNITE(s) Frekote 44NC		
2.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs PRÉPARATION DU MOULE  Faire la préparation du moule N° DT 8004 à l'aide de Frekote 44NC et laisser sécher pendant 3 heures selon le QSI-006.  Date: <u>AUG 21 2007</u> Heure Début: <u>12:30</u> Heure Fin: <u>3:00</u> Sceau:		
3.0	AC0409	Tissu à délaminer Release ply B
Commentaire Qty.: 9.84 VERGE(s)/Unit Total : 9.84 VERGE(s) Tissu à délaminer Release ply B		
4.0	AC0407	Wrightlon 5200 Bleu P3
Commentaire Qty.: 9.27 VERGE(s)/Unit Total : 9.27 VERGE(s) Wrightlon 5200 Bleu P3		
5.0	AC0408	Feutre de drainage N° Airweave N 10
Commentaire Qty.: 6.00 VERGE(s)/Unit Total : 6.00 VERGE(s) Feutre de drainage N° Airweave N 10		
6.0	AC0752	Stretchlon 200 poche à vide Vert
Commentaire Qty.: 7.00 VERGE(s)/Unit Total : 7.00 VERGE(s) Stretchlon 200 poche à vide Vert		



Date: Lundi, 2007-08-20 11:18:11

Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD BODY R/H

Numéro Job: 42035

Numéro Article: DKC134-0055

Numéro Job:



# Séq.: Machine ou Opération: Description :

7.0 AAC0681 9.7 oz Weave #FG-778150-125Y Volan Finish

Commentaire Qty.: 11.400 VERGE(s)/Unit Total: 11.400 VERGE(s)

9.7 oz Weave #FG-778150-125Y Volan Finish

#LOT: 2-6093-1

8.0 AAC0443 Fiberglass 12 oz Unidirectional

Commentaire Qty.: 0.80 VERGE(s)/Unit Total: 0.80 VERGE(s)

Fiberglass 12 oz Unidirectional

N° de Lot: 1-5964-1

9.0 AAC0633 WR1850 ROVING 18 OZ x 50"

Commentaire Qty.: 0.35 VERGE(s)/Unit Total: 0.35 VERGE(s)

WR1850 ROVING 18 OZ x 50"

N° de Lot: 1-6113-3

10.0 AC0098 Ruban à gommer jaune #: T/AT-200Y

Commentaire Qty.: 4.0000 RL(s)/Unit Total: 4.0000 RL(s)

Ruban à gommer jaune #: T/AT-200Y

11.0 PRÉPARATION 3

PRÉPARATION DU MATÉRIEL DART



Commentaire Setup: 0.00Hrs/ Run: 45.0000Min Total Run: 0.7500Hrs

TAILLAGE DU MATÉRIEL

Tailler le matériel, selon les différents patrons de découpe et les quantités inscrites sur ceux-ci.

À fin d'accélérer le processus de taillage, tailler les plis de 9.7 oz tous en même temps en les superposants les uns sur les autres.

Date: 6/6/07 Heure Début: 12:30 Heure Fin: 4:30 Sceau:



12.0 AAC0275 Catalyst N° DDM-9

Commentaire Qty.: 0.0640 PINTE(s)/Unit Total: 0.0640 PINTE(s)

Catalyst N° DDM-9

N° de Lot: 1-6118-3

13.0 AAC0324 Résine (411B7530) 411-350 promo. 75min.

Commentaire Qty.: 2.000 KILOGRAMME(s)/Unit Total: 2.000 KILOGRAMME(s)

Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-6271-1

14.0 AAC0673 Fibre de verre Miapoxy 66

Commentaire Qty.: 0.0039 GALLON(s)/Unit Total: 0.0039 GALLON(s)

Fibre de verre Miapoxy 66

N° de Lot: 1-5951-1

15.0 PRÉPARATION 3

PRÉPARATION DU MATÉRIEL DART



Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run: 0.0833Hrs

PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantités requises, mix ration 1.5% de Catalyst N° DDM-9 par quantité de résine N° 411-350.

ate: Lundi, 2007-08-20 11:18:11  
Utilisateur: Marc Dubé

## Feuille de Procédé

Cliant: DART Dart Aerospace Ltd.  
Numéro Job: 42035

Nom Dessin: SPACEPOD BODY R/H  
Numéro Article: DKC134-0055

Numéro Job:



# Séq.: Machine ou Opération: Description :

Préparer une seringue de 30 ml de résine chargée de fibre de verre miapoxy 66

Date: AUG 22 2007 Heure Début: 8:15 Heure Fin: 8:20 Sceau:

16.0

LAMINAGE.

LAMINAGE PIÈCE DART



Commentaire Setup: 0.00Hrs/ Run: 90.0000Min Total Run : 1.5000Hrs  
FAIRE LE LAMINAGE DES TISSUS

À l'aide de la seringue, faire un joint tout le tour de la dénivellation pour la porte directement dans le moule.

À l'aide d'un rouleau 2" dia. appliquer une couche de résine N° 411-350 sur le moule N° DT 8004 et ensuite imbiber un pli de tissu 9.7oz. et 18 oz. sur la section supérieur de la pièce.

Laminage du 12 oz.

Recommencer l'opération pour le deuxième pli.

Date: AUG 22 2007 Heure Début: 8:20 Heure Fin: 9:00 Sceau:

17.0

POCHE À VIDE 1

FAIRE LA POCHE À VIDE



Commentaire Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs  
EFFECTUER LA POCHE A VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Tissu à délaminer,
- 2- Film perforé P-3,
- 3- Feutre de drainage
- 4- Sac à vide Stretchlon 200

Laisser sécher pendant 4 heures minimum.

Date: AUG 22 2007 Heure Début: 9:00 Heure Fin: 9:20 Sceau:

Curing Début: 8:20 Curing Fin: 2:00

18.0

AAC0457












ATC core-cell A500 plain 4'x8' 1" thick

Commentaire Qty.: 0.75 FEUILLE(s)/Unit Total : 0.75 FEUILLE(s)  
ATC core-cell A500 plain 4'x8' 1" thick Selon dessin D3188 de Dart

N° de Lot: 3-5915-2














ite: Lundi, 2007-08-20 11:18:11  
ilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.		Nom Dessin: SPACEPOD BODY R/H	
Numéro Job: 42035		Numéro Article: DKC134-0055	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
19.0	FAB GÉNÉRALE 3 	FABRICATION GÉNÉRALE DART 	
<b>Commentaire</b> Setup: 0.00Hrs/ Run: 120.0000Min Total Run : 2.0000Hrs TAILLAGE DU MATÉRIEL  Tailler le Foam Core 1" selon le plan de découpe et les gabarits Date: <u>AUG 23 2007</u> Heure Début: <u>9:30</u> Heure Fin: <u>12:00</u> Sceau: 			
20.0	AAC0324	Résine (411B7530) 411-350 promo. 75min.	
<b>Commentaire</b> Qty.: 0.200 KILOGRAMME(s)/Unit Total : 0.200 KILOGRAMME(s) Résine (411B7530) 411-350 promo. 75min. N° de Lot: <u>1-6271-1</u>			
21.0	AAC0275	Catalyst N° DDM-9	
<b>Commentaire</b> Qty.: 0.0064 PINTE(s)/Unit Total : 0.0064 PINTE(s) Catalyst N° DDM-9 N° de Lot: <u>1-618-3</u>			
22.0	FINITION 3 	FINITION PIÈCE DART 	
<b>Commentaire</b> Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs FINITION PIÈCE DART AUG 23 2007  Prendre les deux pièces de 11" x 57" et sceller la grande surface sur chacune d'elle selon I.G. # Sceller le Foam Core.			
23.0	AAC0452	Polybond B46F	
<b>Commentaire</b> Qty.: 0.010 KIT(s)/Unit Total : 0.010 KIT(s) Polybond B46F N° de Lot: <u>1-6172-1</u>			
24.0	FINITION 3 	FINITION PIÈCE DART 	
<b>Commentaire</b> Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs FINITION PIÈCE DART  À l'aide du Polybond, coller ensemble les deux surfaces scellées  Disposer des poind sur les pièces pour conserver une pression de collage.  Laisser sécher pour un minimum de deux heures. Quantité: <u>1</u> Date: <u>AUG 23 2007</u> Sceau:  			

Date: Lundi, 2007-08-20 11:18:11  
Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.		Nom Dessin: SPACEPOD BODY R/H	
Numéro Job: 42035		Numéro Article: DKC134-0055	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
Quantité: _____ Date: _____ Sceau: _____			
25.0	TRIMAGE 3	TRIMAGE COMPOSITES DART	
			
<b>Commentaire</b> Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs TRIMAGE COMPOSITES DART  Ajuster à l'aide du thermoformeur 4" x 8" chacune des pièces de foam core dans le moule selon le dessin. Quantité: <u>1</u> Date: <u>AUG 23 2007</u> Sceau:   Quantité: _____ Date: _____ Sceau: _____			
26.0	AAC0324	Résine (411B7530) 411-350 promo. 75min.	
<b>Commentaire</b> Qty.: 0.300 KILOGRAMME(s)/Unit Total : 0.300 KILOGRAMME(s) Résine (411B7530) 411-350 promo. 75min. N° de Lot: <u>1-6271-1</u>			
27.0	AAC0275	Catalyst N° DDM-9	
<b>Commentaire</b> Qty.: 0.0096 PINTE(s)/Unit Total : 0.0096 PINTE(s) Catalyst N° DDM-9 N° de Lot: <u>1-6118-3</u>			
28.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART	
			
<b>Commentaire</b> Setup: 0.00Hrs/ Run: 10.0000Hrs Total Run : 10.0000Hrs PRÉPARATION DU MATÉRIEL DART  AUG 23 2007   Faire la préparation de la résine selon les quantités requises, mix ration 1.5% de Catalyst N° DDM-9 par quantité de résine N° 411-350 promu 75 minutes..			
29.0	FAB GÉNÉRALE 3	FABRICATION GÉNÉRALE DART	
			
<b>Commentaire</b> Setup: 0.00Hrs/ Run: 20.0000Hrs Total Run : 20.0000Hrs FABRICATION GÉNÉRALE PLASTIC COMMERCIAL  Retirer les pièces de foam core du moule  Sceller les foam core à l'aide de la résine promu N° 411-350 75 minutes. Selon I.G.# Sceller le foam Core.  Laisser sécher pendant 2 heures minimum Date: <u>AUG 23 2007</u> Sceau:   Initiales: <u>M.G.C.G</u>			

ate: Lundi, 2007-08-20 11:18:11  
tilisateur: Marc Dubé

## Feuille de Procédé

Cliant: DART Dart Aerospace Ltd.  
Numéro Job: 42035

Nom Dessin: SPACEPOD BODY R/H  
Numéro Article: DKC134-0055

Numéro Job:



# Séq.: Machine ou Opération: Description :

30.0 AAC0452 Polybond B46F

Commentaire Qty.: 0.078 KIT(s)/Unit Total: 0.078 KIT(s)  
Polybond B46F N° de Lot: 1-6233-1

31.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs  
PRÉPARATION DU MATÉRIEL

Faire la préparation du Poly bond.

Date: AUG 24 2007

Heure Début: 7:30 Heure Fin: 7:45 Sceau: 65

32.0 ASSEMBLAGE 3 ASSEMBLAGE GÉNÉRALE DART



Commentaire Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs  
ASSEMBLAGE GÉNÉRALE DES PIÈCES

Coller les différents pièces de Foam Core dans les Spacepod Body à l'aide du Poly bond.

Date: AUG 24 2007

Heure Début: 7:45 Heure Fin: 8:15 Sceau: 65



33.0 POCHÉ À VIDE 1 FAIRE LA POCHÉ À VIDE



Commentaire Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs  
EFFECTUER LA POCHÉ A VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Tissu à délaminer,
- 2- Film perforé P-3,
- 3- Feutre de drainage
- 4- Sac à vide Stretchlon 200

Laisser sécher pendant 2 heures minimum.

Retirer le bagging entre 1 heure et 1 heure 1/2 après le mélange de la résine afin d'enlever le surplus de polybond avant que celui-ci ne soit complètement polymérisé.

Date: AUG 24 2007

Heure Début: 8:15 Heure Fin: 8:35 Sceau: 65



Curing Début: 7:45 Curing Fin: 9:00

Date: Lundi, 2007-08-20 11:18:11  
Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.  
Numéro Job: 42035

Nom Dessin: SPACEPOD BODY R/H  
Numéro Article: DKC134-0055

Numéro Job:



# Séq.: Machine ou Opération: Description :

34.0 AC0058 Polysoft 1.3 kg # 003012 Sikkens

Commentaire Qty.: 0.100 UNITE(s)/Unit Total : 0.100 UNITE(s)  
Polysoft 1.3 kg # 003012 Sikkens

N° de Lot: 1-6227-1

35.0 AC0059 Durcisseur Polysoft #004009 Sikkens

Commentaire Qty.: 0.078 UNITE(s)/Unit Total : 0.078 UNITE(s)  
Durcisseur Polysoft #004009 Sikkens

36.0 FINITION 3 FINITION PIÈCE DART



Commentaire Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs  
FINITION GÉNÉRALE

Corriger les petits défauts de surface de la pièce avec du Sikkens. Pour les plus gros défauts utiliser du polybond

Date: AUG 27 2007 Heure Début: 7:30 Heure Fin: 11:00 Sceau:

37.0 TRIMAGE 3 TRIMAGE COMPOSITES DART



Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs  
TRIMAGE COMPOSITES DART

Tailler le foam core afin d'ajuster le contour de la pièce à celui du moule.

AUG 27 2007



38.0 AAC0324 Résine (411B7530) 411-350 promo. 75min.

Commentaire Qty.: 0.100 KILOGRAMME(s)/Unit Total : 0.100 KILOGRAMME(s)  
Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-6271-1

39.0 AAC0275 Catalyst N° DDM-9

Commentaire Qty.: 0.0032 PINTE(s)/Unit Total : 0.0032 PINTE(s)  
Catalyst N° DDM-9

N° de Lot: 1-6118-3

40.0 FINITION 3 FINITION PIÈCE DART



Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs  
FINITION PIÈCE DART

Sceller le foam core qui a été exposé suite au taillage précédent selon I.G. # Sceller le Foam Core













Laisser sécher pendant minimum deux heures.

AUG 27 2007



ate: Lundi, 2007-08-20 11:18:11  
utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.		Nom Dessin: SPACEPOD BODY R/H	
Numéro Job: 42035		Numéro Article: DKC134-0055	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
41.0	AAC0275	Catalyst N° DDM-9	
Commentaire Qty.: 0.0504 PINTE(s)/Unit Total : 0.0504 PINTE(s) Catalyst N° DDM-9 N° de Lot: <u>1-6118-3</u>			
42.0	AAC0324	Résine (411B7530) 411-350 promo. 75min.	
Commentaire Qty.: 1.500 KILOGRAMME(s)/Unit Total : 1.500 KILOGRAMME(s) Résine (411B7530) 411-350 promo. 75min. N° de Lot: <u>1-6271-1</u>			
43.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART	
			
Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs PRÉPARATION DU MATÉRIEL  Faire la préparation de la résine selon les quantité requises, mix ratio 1.5% de Catalyst N° DDM-9 par quantité de résine N° 411-350. Date: <u>AUG 28 2007</u> Heure Début: <u>8:45</u> Heure Fin: <u>8:50</u> Sceau: 			
44.0	INSPECTION 3	INSPECTION PIÈCE DART	
			
Commentaire Setup: 0.00Hrs/ Run: 90.0000Min Total Run : 1.5000Hrs FAIRE LE LAMINAGE DES TISSUS  Laminer deux pli de 9.7 oz 7781 partout dans le moule.  Le laminage doit être fait à l'aide de la résine N° 411-350 / 2% DDM-9. Date: <u>AUG 28 2007</u> Heure Début: <u>8:50</u> Heure Fin: <u>9:35</u> Sceau:    			
45.0	POCHE À VIDE 1	FAIRE LA POCHE À VIDE	
			
Commentaire Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs EFFECTUER LA POCHE A VIDE  Faire la poche à vide en appliquant les composantes dans l'ordre suivant:  1- Tissu à délaminer, 2- Film perforé P-3, 3- Feutre de drainage 4- Sac à vide Stretchlon 200  Laisser sécher pendant 4 heures minimum.			



Date: Lundi, 2007-08-20 11:18:11

Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD BODY R/H

Numéro Job: 42035

Numéro Article: DKC134-0055

Numéro Job:



# Séq.:

Machine ou Opération:

Description:

Date: AUG 28 2007 Heure Début: 9:35 Heure Fin: 9:35 Sceau:Curing Début: 8:50 Curing Fin: 2:00

46.0

DÉMOULAGE 1

DÉMOULAGE PIÈCE DART



Commentaire Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs  
DÉMOULAGE DES PIÈCES

Démouler la pièce en se servant de la prise d'air sous le moule en faisant bien attention de ne pas abimer les différentes surfaces de la pièce.

Date: AUG 29 2007 Heure Début: 7:30 Heure Fin: 8:30 Sceau:

47.0

TRIMAGE 3

TRIMAGE COMPOSITES DART



Commentaire Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs  
TRIMAGE DE FINITION

Percer les 8 trous sur la section supérieur de la pièce ainsi que l'ouverture pour la porte à l'aide du gabarit N° DT5802.

Par l'intérieur, percer les 8 dégagement de ø .745" pour les spacers N° D2213 ( ne pas percer la peau extérieur de la pièce )

Date: AUG 30 2007 Heure Début: 8:30 Heure Fin: 11:00 Sceau:

48.0

AAC0275

Catalyst N° DDM-9

Commentaire Qty.: 0.0048 PINTE(s)/Unit Total : 0.0048 PINTE(s)  
Catalyst N° DDM-9

N° de Lot: 1-6118-3

49.0

AAC0324

Résine (411B7530) 411-350 promo. 75min.

Commentaire Qty.: 0.150 KILOGRAMME(s)/Unit Total : 0.150 KILOGRAMME(s)  
Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-6271-1

50.0

AAC0673








Fibre de verre Miapoxy 66

Commentaire Qty.: 0.0420 GALLON(s)/Unit Total : 0.0420 GALLON(s)  
Fibre de verre Miapoxy 66

N° de Lot: 1-5951-1

Date: Lundi, 2007-08-20 11:18:11  
Utilisateur: Marc Dubé













## Feuille de Procédé

Client: DART Dart Aerospace Ltd.		Nom Dessin: SPACEPOD BODY R/H	
Numéro Job: 42035		Numéro Article: DKC134-0055	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
51.0	PRÉPARATION 3 	PRÉPARATION DU MATÉRIEL DART 	
<p><b>Commentaire</b> Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs PRÉPARATION DU MATÉRIEL</p> <p>Faire la préparation de la résine selon les quantités requises, mix ratio 1.5% de Catalyst N° DDM-9 par quantité de résine N° 411-350.</p> <p>Date: <u>SEP 04 2007</u> Heure Début: <u>1:30</u> Heure Fin: <u>1:35</u> Sceau: </p>			
52.0	AAC0448	Spacer N° D2213	
<p><b>Commentaire</b> Qty.: 8 UNITE(s)/Unit Total: 8 UNITE(s) Spacer N° D2213 N° de Lot: <u>1-5949-1</u></p>			
53.0	ASSEMBLAGE 3 	ASSEMBLAGE GÉNÉRALE DART 	
<p><b>Commentaire</b> Setup: 0.00Hrs/ Run: 45.0000Min Total Run : 0.7500Hrs ASSEMBLAGE GÉNÉRALE DES PIÈCES</p> <p>Faire l'assemblage des inserts ( Spacer ) N° D2213 dans les trous prévus à cet effet à l'aide de résine N° 411-350 chargé à l'aide de Fibre de verre courte Miapoxy 66.</p> <p>Laminer un pièce de 9 oz. sur chacune des 2 zones de 4 spacers pour reboucher les trous</p> <p>Appliquer une pression sur les pièces de 9 oz à l'aide d'un bloc de bois et de pinces autobloquantes</p> <p>Laisser sécher pendant 4 heures minimum.</p> <p>Date: <u>SEP 04 2007</u> Heure Début: <u>1:35</u> Heure Fin: <u>2:35</u> Sceau: </p> <p>Curing Début: <u>1:35</u> Curing Fin: <u>8:00</u></p>			
54.0	AAC0275	Catalyst N° DDM-9	
<p><b>Commentaire</b> Qty.: 0.0096 PINTE(s)/Unit Total: 0.0096 PINTE(s) Catalyst N° DDM-9</p> <p>N° de Lot: <u>1-6118-3</u></p>			
55.0	AAC0324	Résine (411B7530) 411-350 promo. 75min.	
<p><b>Commentaire</b> Qty.: 0.300 KILOGRAMME(s)/Unit Total: 0.300 KILOGRAMME(s) Résine (411B7530) 411-350 promo. 75min.</p> <p>N° de Lot: <u>1-6271-1</u></p>			

Date: Lundi, 2007-08-20 11:18:11

Utilisateur: Marc Dubé










## Feuille de Procédé

Client: DART Dart Aerospace Ltd.		Nom Dessin: SPACEPOD BODY R/H	
Numéro Job: 42035		Numéro Article: DKC134-0055	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
56.0	PRÉPARATION 3 	PRÉPARATION DU MATÉRIEL DART 	
<p>Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs PRÉPARATION DU MATÉRIEL</p> <p>Faire la préparation de la résine selon les quantité requises, mix ration 1.5% de Catalyst N° DDM-9 par quantité de résine N° 411-350.</p> <p>Date: <u>AUG 30 2007</u> Heure Début: <u>3:15</u> Heure Fin: <u>3:20</u> Sceau: </p>			
57.0	LAMINAGE. 	LAMINAGE PIÈCE DART 	
<p>Commentaire Setup: 0.00Hrs/ Run: 55.0000Min Total Run : 0.9167Hrs FAIRE LE LAMINAGE DES TISSUS</p> <p>Retirer les pinces et blocs de bois</p> <p>Faire le laminage d'un pli de 9.7 oz 7781 sur le contour de la pièces. Selon le dessin.</p> <p>Laisser sécher pendant 4 heures minimum.</p> <p>Date: <u>AUG 30 2007</u> Heure Début: <u>3:20</u> Heure Fin: <u>4:15</u> Sceau:  </p> <p>Curing Début: <u>3:20</u> Curing Fin: <u>8:00</u></p>			
58.0	FINITION 3 	FINITION PIÈCE DART 	
<p>Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs FINITION PIÈCE DART</p> <p>1 Repercer les 8 trous des spacers afin de les déboucher <u>05-09-07</u> </p> <p>2 Sabler les surfaces de la pièces pour aider à l'adhésion du primer et enlever les imperfections. <u>06-9-07</u> </p>			
59.0	AAC0671	Dupont Primer N° 1104S	
<p>Commentaire Qty.: 0.5000 GALLON(s)/Unit Total : 0.5000 GALLON(s) Dupont Primer N° 1104S</p> <p>N° de Lot: <u>1-6282-1</u></p>			
60.0	AAC0670	Dupont Activator N° 7975S	
<p>Commentaire Qty.: 1.0000 PINTE(s)/Unit Total : 1.0000 PINTE(s) Dupont Activator N° 7975S</p> <p>N° de Lot: <u>1-6254-1</u></p>			

Date: Lundi, 2007-08-20 11:18:12












Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.		Nom Dessin: SPACEPOD BODY R/H	
Numéro Job: 42035		Numéro Article: DKC134-0055	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
61.0	AAC0672	Dupont Reducer N° 12375S	
<p>Commentaire Qty.: 0.1250 GALLON(s)/Unit Total : 0.1250 GALLON(s)          Dupont Reducer N° 12375S          N° de Lot: <u>1-5769-3</u></p>			
62.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART	
			
<p>Commentaire Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs          PRÉPARATION DU MATÉRIEL DART          Bien brasser les trois contenants servant à faire le mélange du primer gris N° 1104S et ensuite faire le mélange selon les instruction du fabriquant.</p>			
63.0	PEINT/ PRIMER2	PEINTURE / PRIMER DART	
			
<p>Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs          PEINTURE / PRIMER DART          Appliquer une couche de primer Dupont N° 1104S ( 7975S Activator, 12375S Reducer ) selon I.G. #          Application du primer          Laisser sécher pendant 3 heures minimum          Date: <u>06-9-07</u> Heure Début: <u>3:20</u> Heure Fin: <u>4:15</u> Sceau: </p>			
64.0	AC0058	Polysoft 1.3 kg # 003012 Sikkens	
<p>Commentaire Qty.: 0.020 UNITE(s)/Unit Total : 0.020 UNITE(s)          Polysoft 1.3 kg # 003012 Sikkens          N° de Lot: <u>1-6227-1</u></p>			
65.0	AC0059	Durcisseur Polysoft #004009 Sikkens	
<p>Commentaire Qty.: 0.078 UNITE(s)/Unit Total : 0.078 UNITE(s)          Durcisseur Polysoft #004009 Sikkens</p>			
66.0	FINITION 3	FINITION PIÈCE DART	
			
<p>Commentaire Setup: 0.00Hrs/ Run: 90.0000Min Total Run : 1.5000Hrs          FINITION GÉNÉRALE          Faire les réparations de finition s'il y a lieu à l'aide du Sikkens          Faire un léger sablage ( Grit 220 ) de toute les surfaces.          Date: <u>07-9-07</u> Heure Début: <u>10:15</u> Heure Fin: <u>11:30</u> Sceau: </p>			

Date: Lundi, 2007-08-20 11:18:12  
Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.		Nom Dessin: SPACEPOD BODY R/H	
Numéro Job: 42035		Numéro Article: DKC134-0055	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
67.0	AAC0671	Dupont Primer N° 1104S	
Commentaire Qty.: 0.2500 GALLON(s)/Unit Total : 0.2500 GALLON(s) Dupont Primer N° 1104S N° de Lot: <u>1-6282-1</u>			
68.0	AAC0670	Dupont Activator N° 7975S	
Commentaire Qty.: 0.5000 PINTE(s)/Unit Total : 0.5000 PINTE(s) Dupont Activator N° 7975S N° de Lot: <u>1-6254-1</u>			
69.0	AAC0672	Dupont Reducer N° 12375S	
Commentaire Qty.: 0.0625 GALLON(s)/Unit Total : 0.0625 GALLON(s) Dupont Reducer N° 12375S N° de Lot: <u>1-5769-3</u>			
70.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART	
			
Commentaire Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs PRÉPARATION DU MATÉRIEL			
Bien brasser les trois contenants servant à faire le mélange du primer gris N° 1104S et ensuite faire le mélange selon les instruction du fabriquant.			
71.0	PEINT/ PRIMER2	PEINTURE / PRIMER DART	
			
Commentaire Setup: 0.00Hrs/ Run: 90.0000Min Total Run : 1.5000Hrs APPLICATION DE PRIMER			
Appliquer deux couche de primer Dupont N° 1104S ( 7975S Activator, 12375S Reducer ) selon les instruction du manufacturier, en prenant bien soin d'attendre 10 minutes entre les couches.			
Laisser sécher pendant 3 heures minimum			
Date: <u>07-9-07</u> Heure Début: <u>3:15</u> Heure Fin: <u>4:00</u> Sceau: 			
72.0	INSPECTION 3	INSPECTION PIÈCE DART	
			
Commentaire Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs INSPECTION GÉNÉRALE			
Faire l'inspection générale de la pièces selon le dessin par le département de la qualité.			
Date: <u>11-9-07</u> Sceau:  Initiales: <u>N.S.</u>			
73.0	EMBALLAGE 3	EMBALLAGE PIÈCE DART	
			
Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs EMBALLAGE PIÈCE DART			
Faire l'emballage dans le contenant approprié.			

ate: Lundi, 2007-08-20 11:18:12

utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD BODY R/H

Numéro Job: 42035

Numéro Article: DKC134-0055

Numéro Job:



# Séq.:

Machine ou Opération:

Description :

Quantité: 1 Date: 17/9/07 Sceau: 

Quantité: \_\_\_\_\_ Date: \_\_\_\_\_ Sceau: \_\_\_\_\_